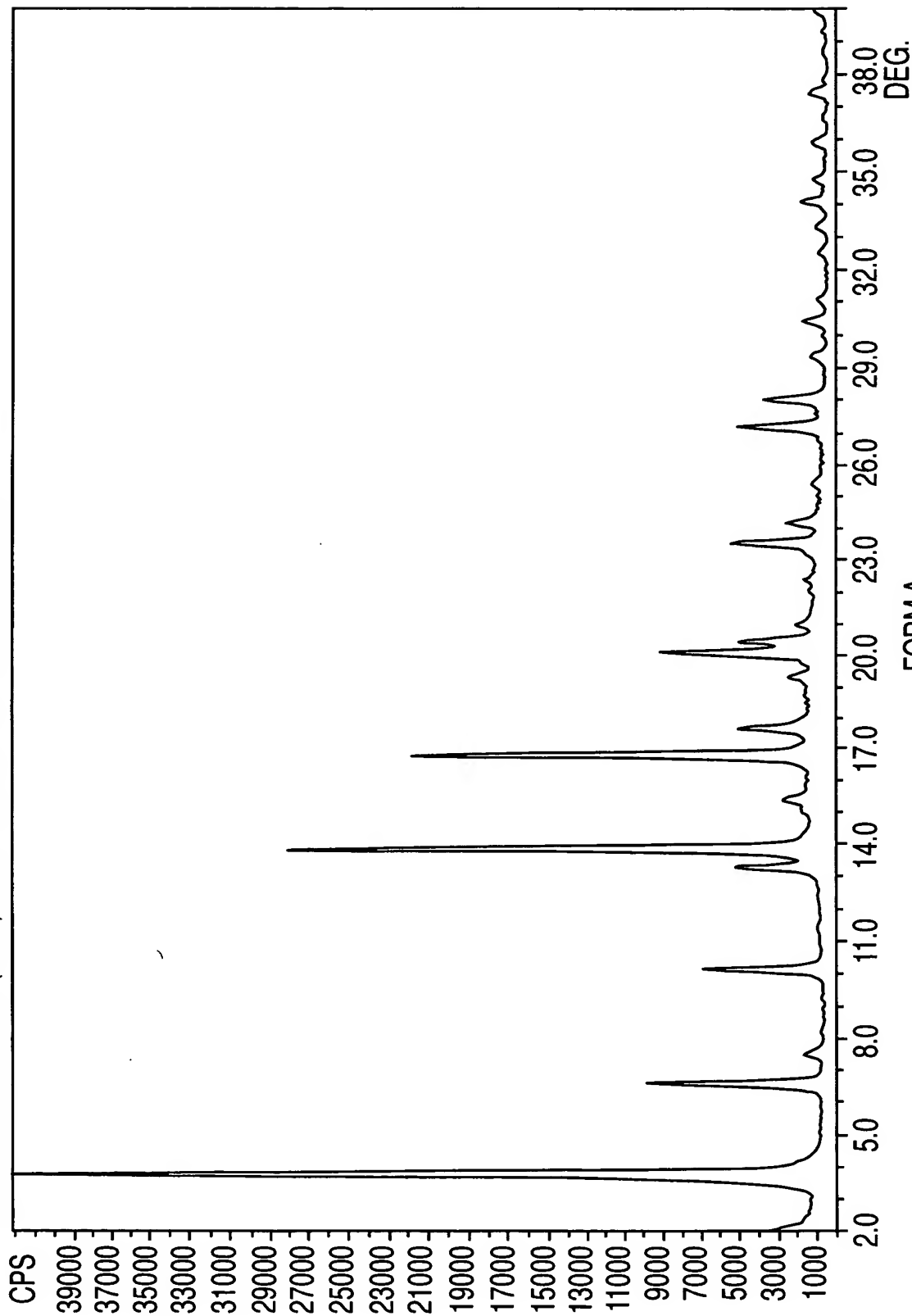




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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

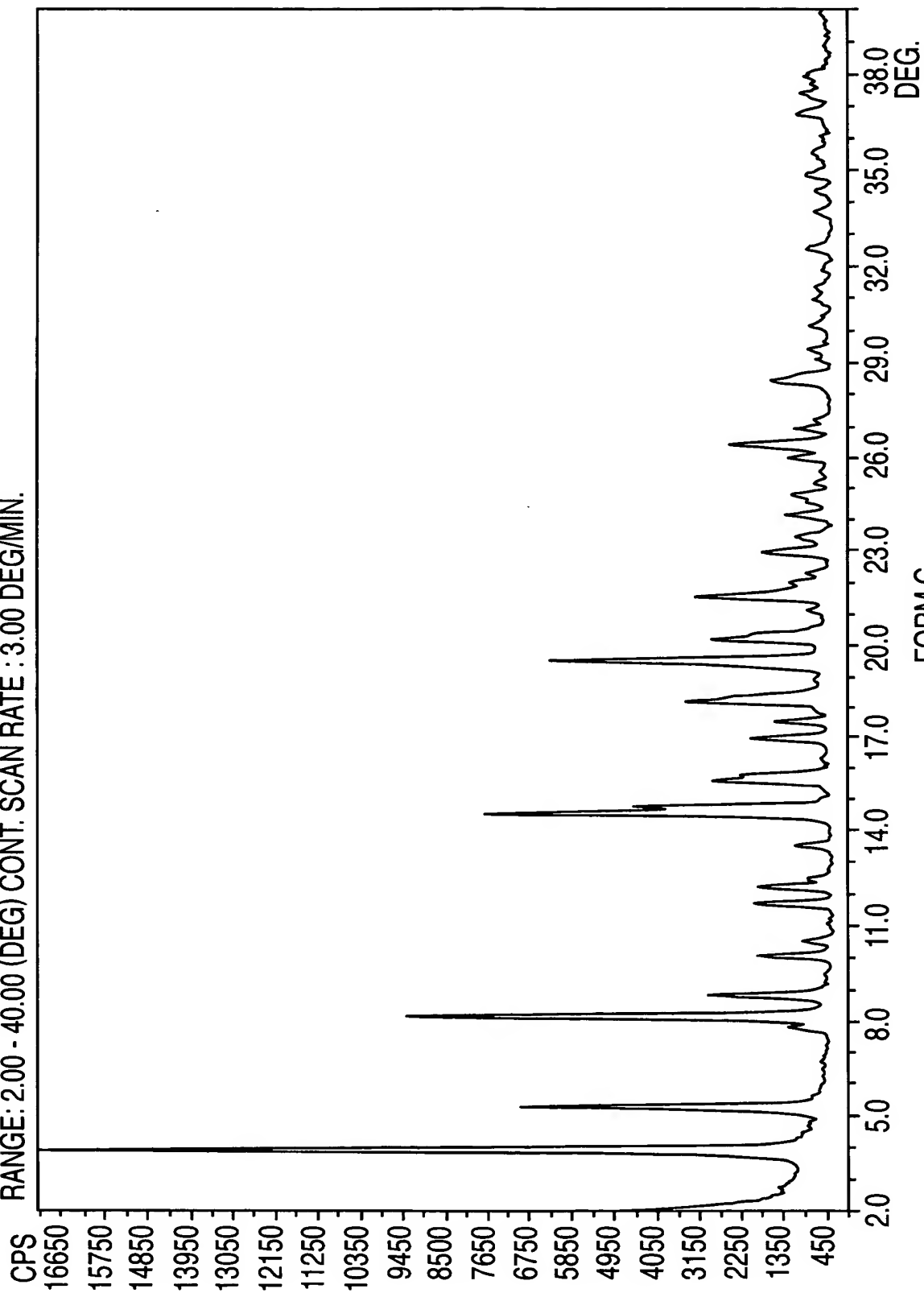


FORMA

FIG. 1

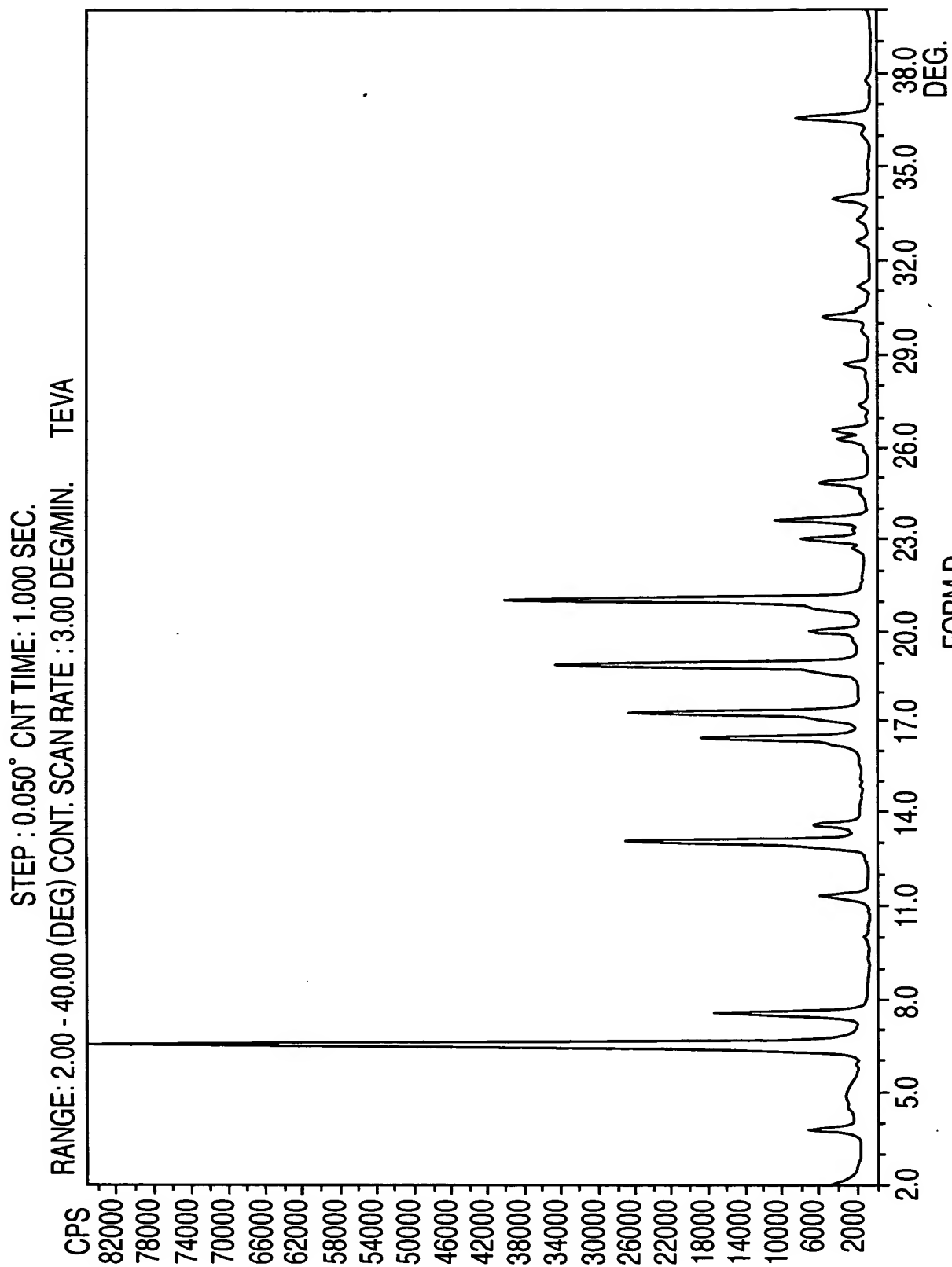
⊗

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



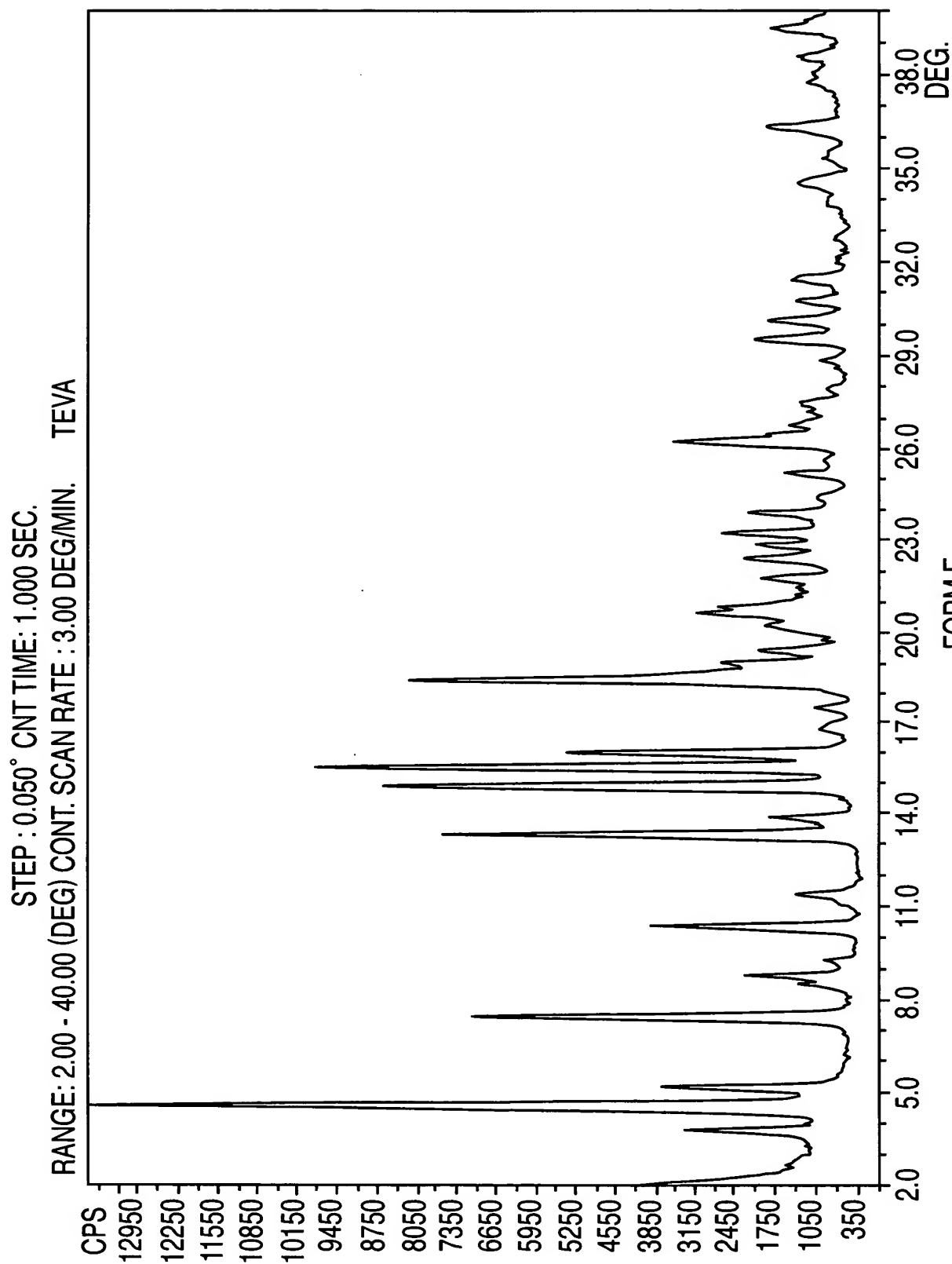
FORM C

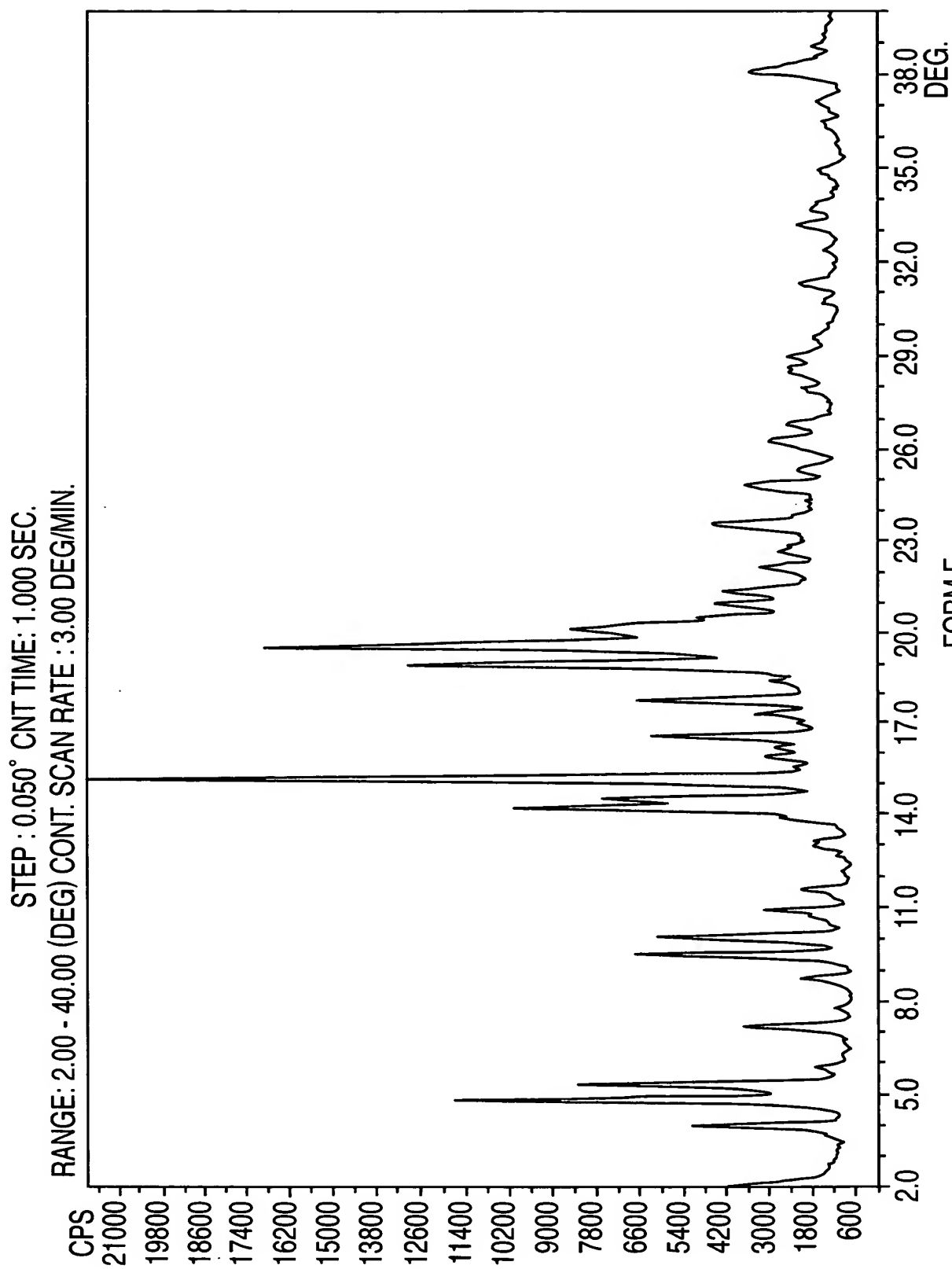
FIG. 2



FORM D

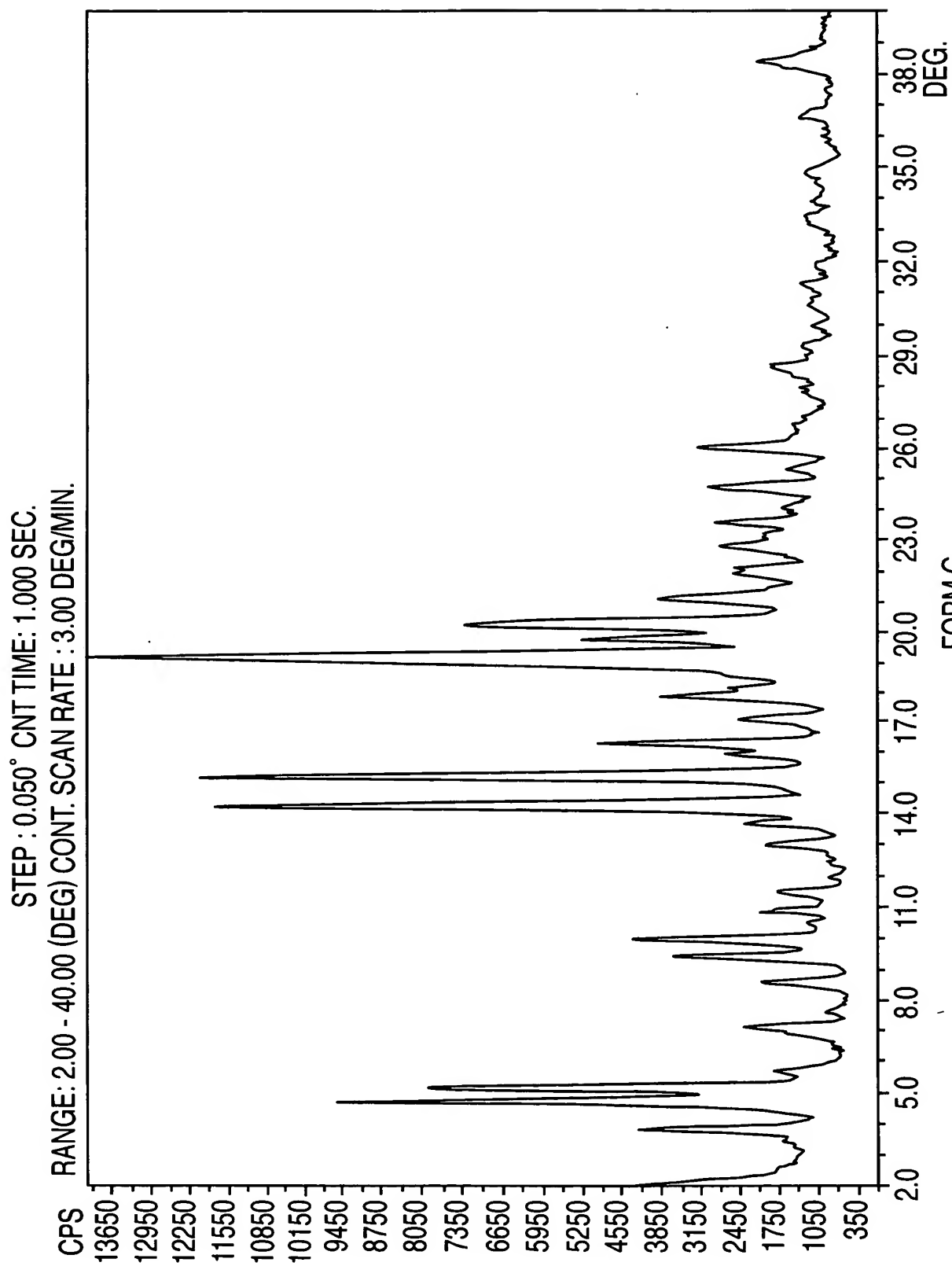
FIG. 3





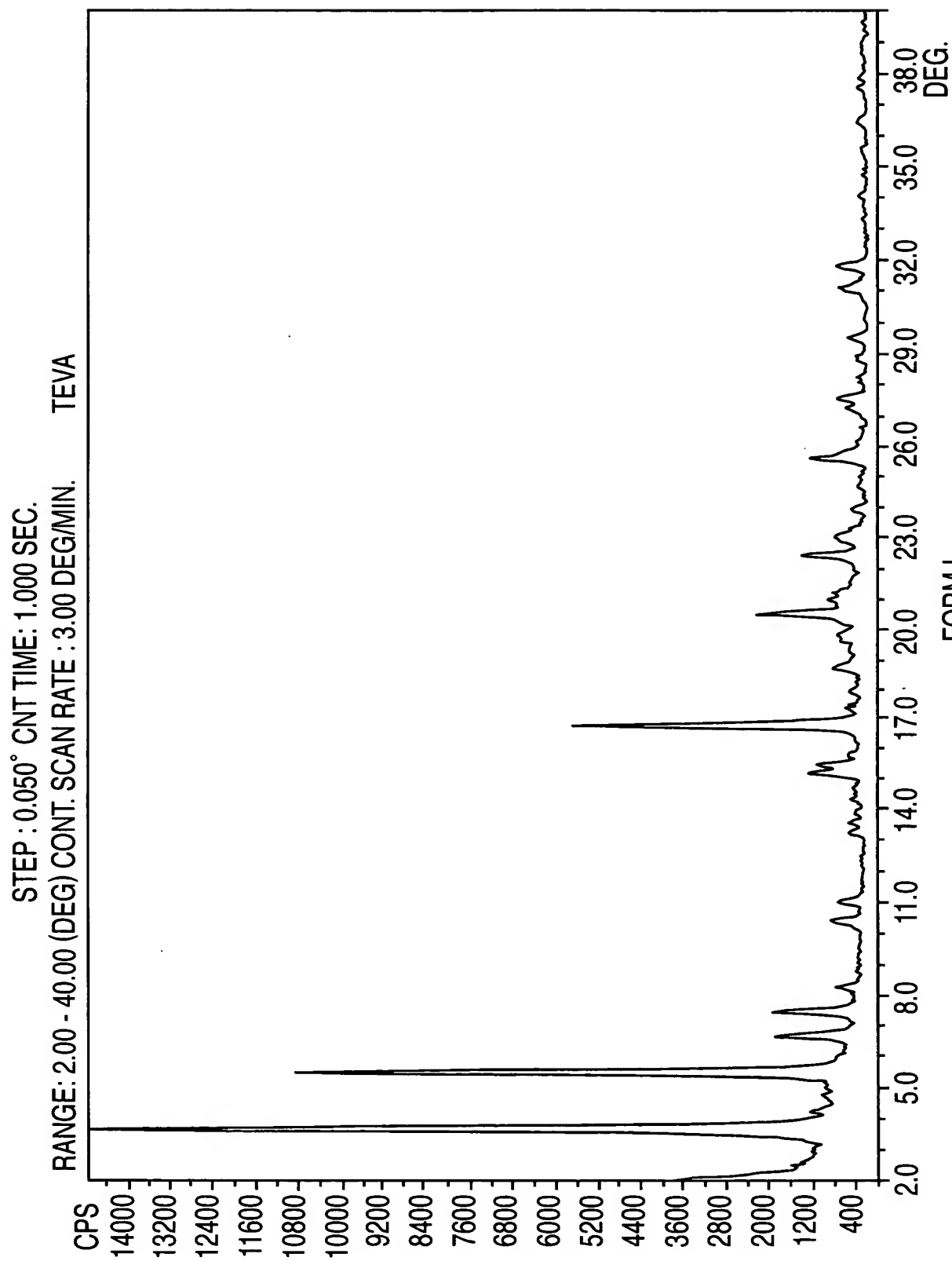
FORM F

FIG. 5



FORM G

FIG. 6



FORM I

FIG. 7

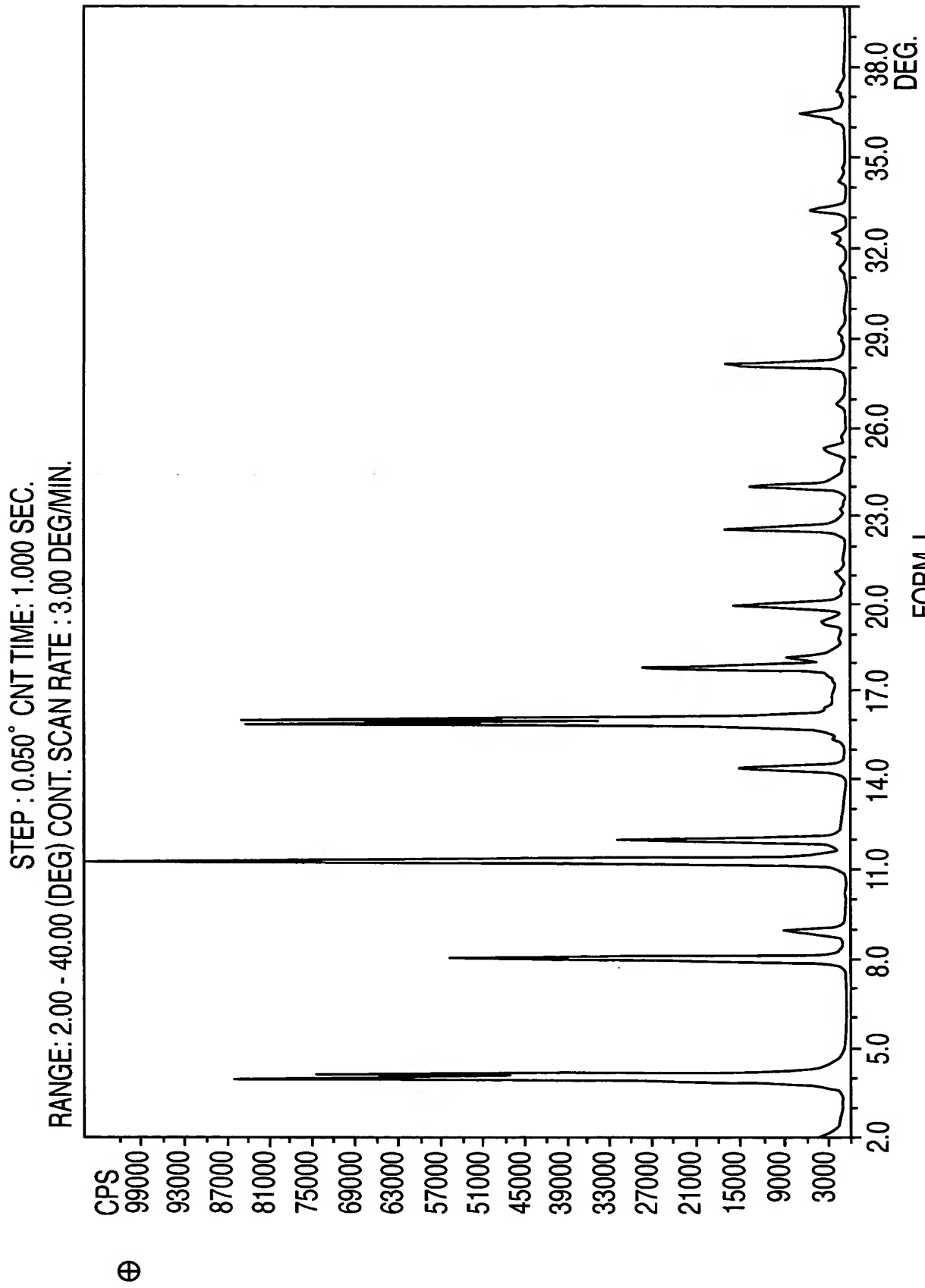
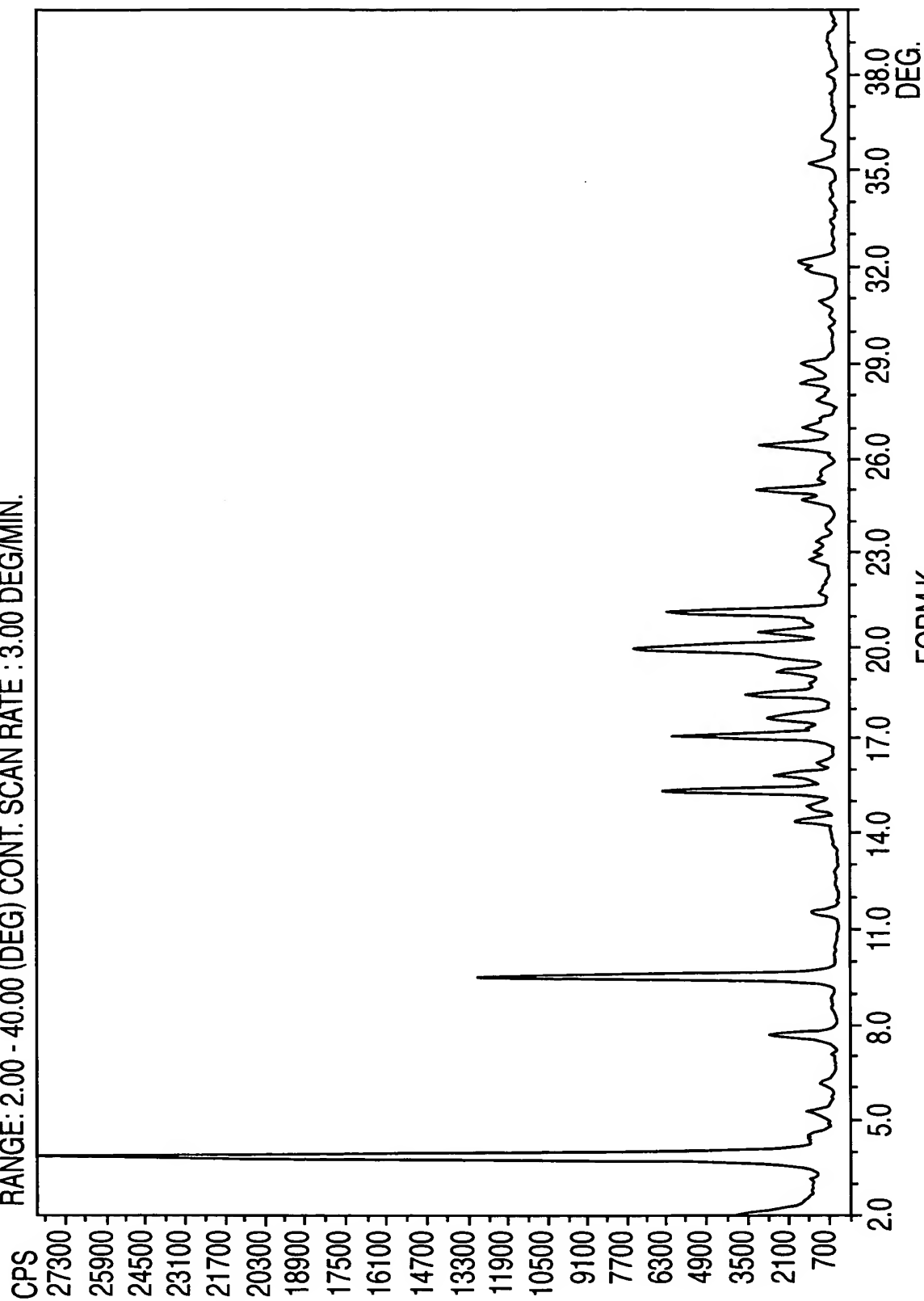


FIG. 8

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM K

FIG. 9

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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

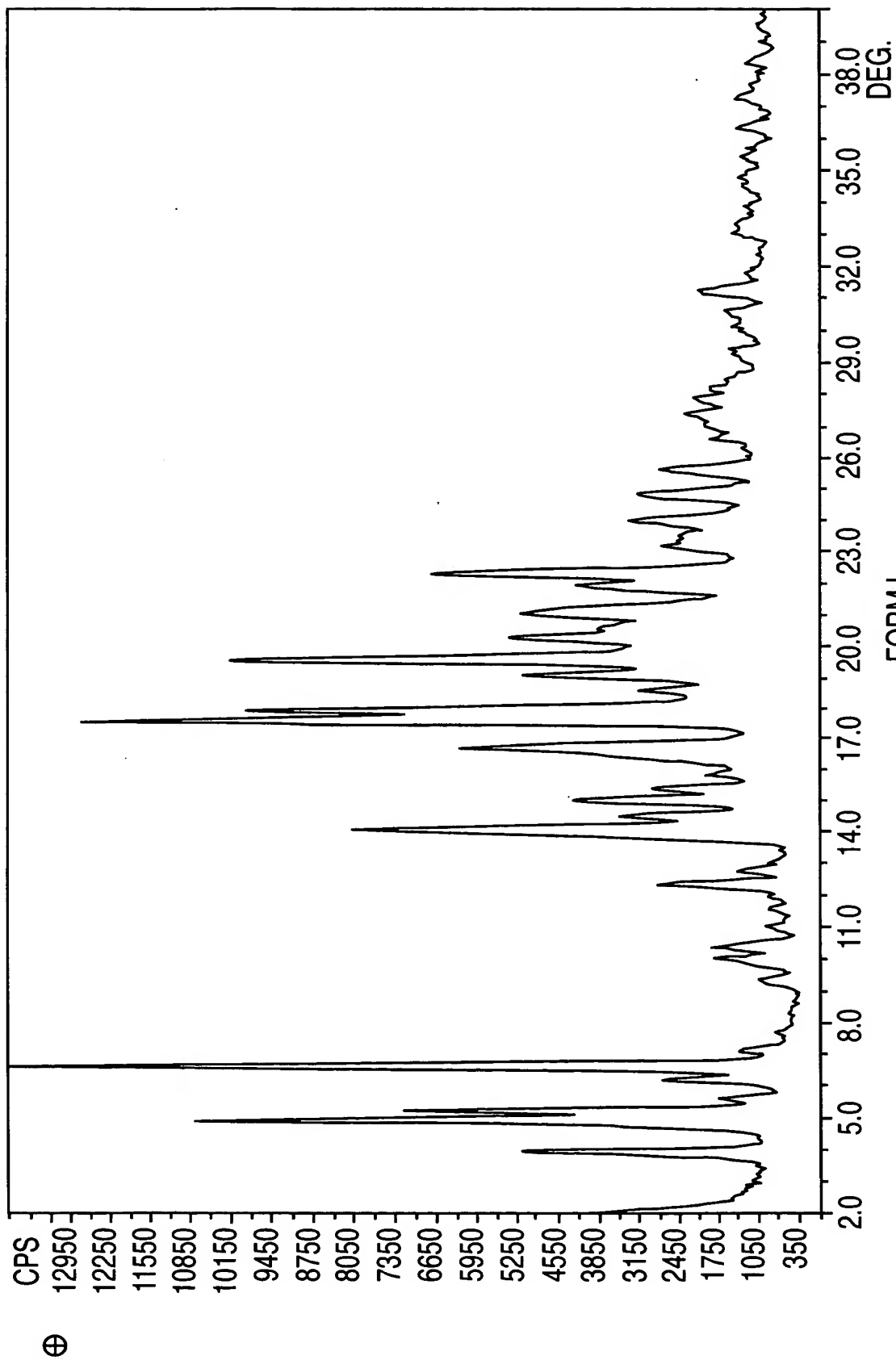
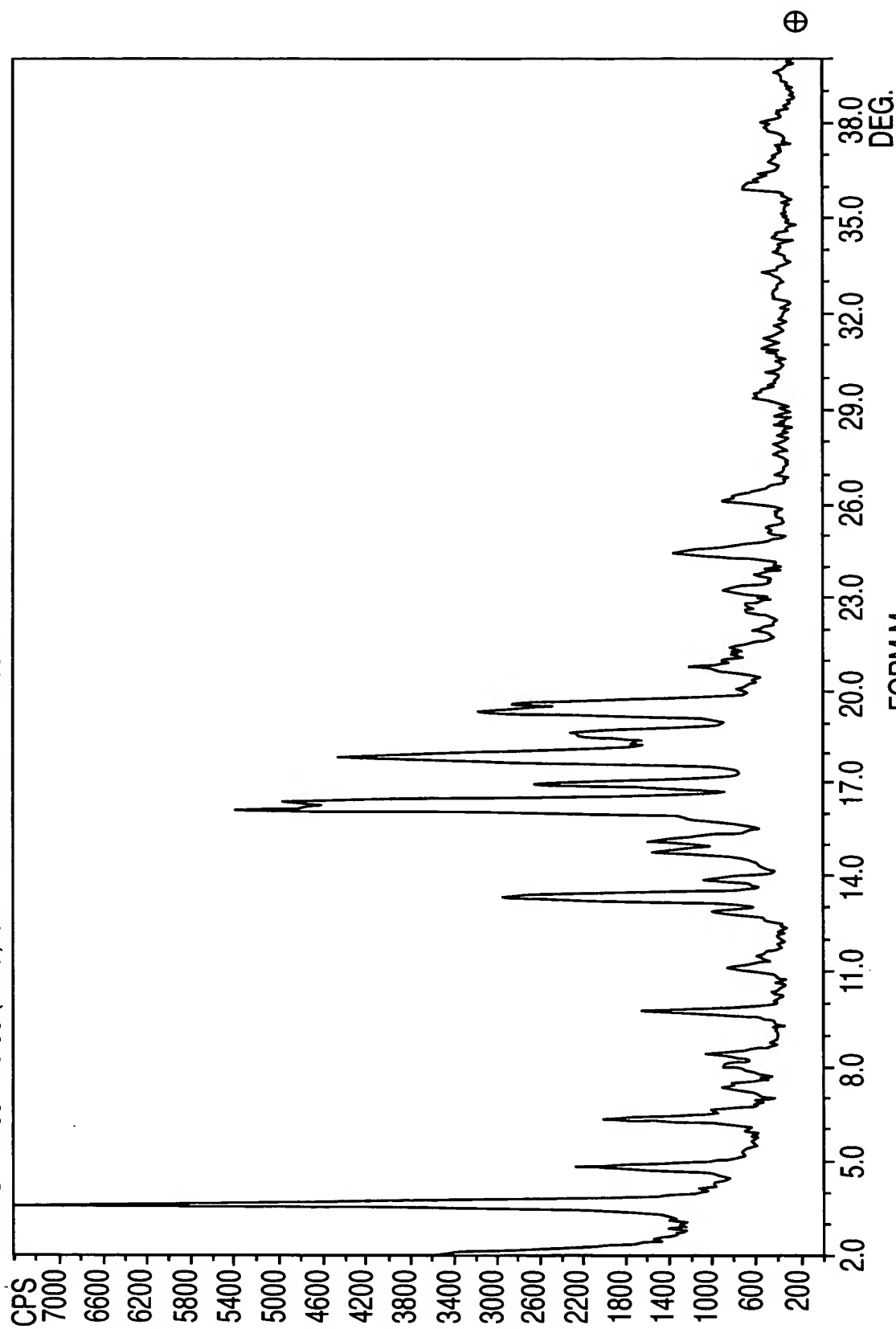


FIG. 10

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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CNT. SCAN RATE : 3.00 DEG/MIN.



FORM M

FIG. 11

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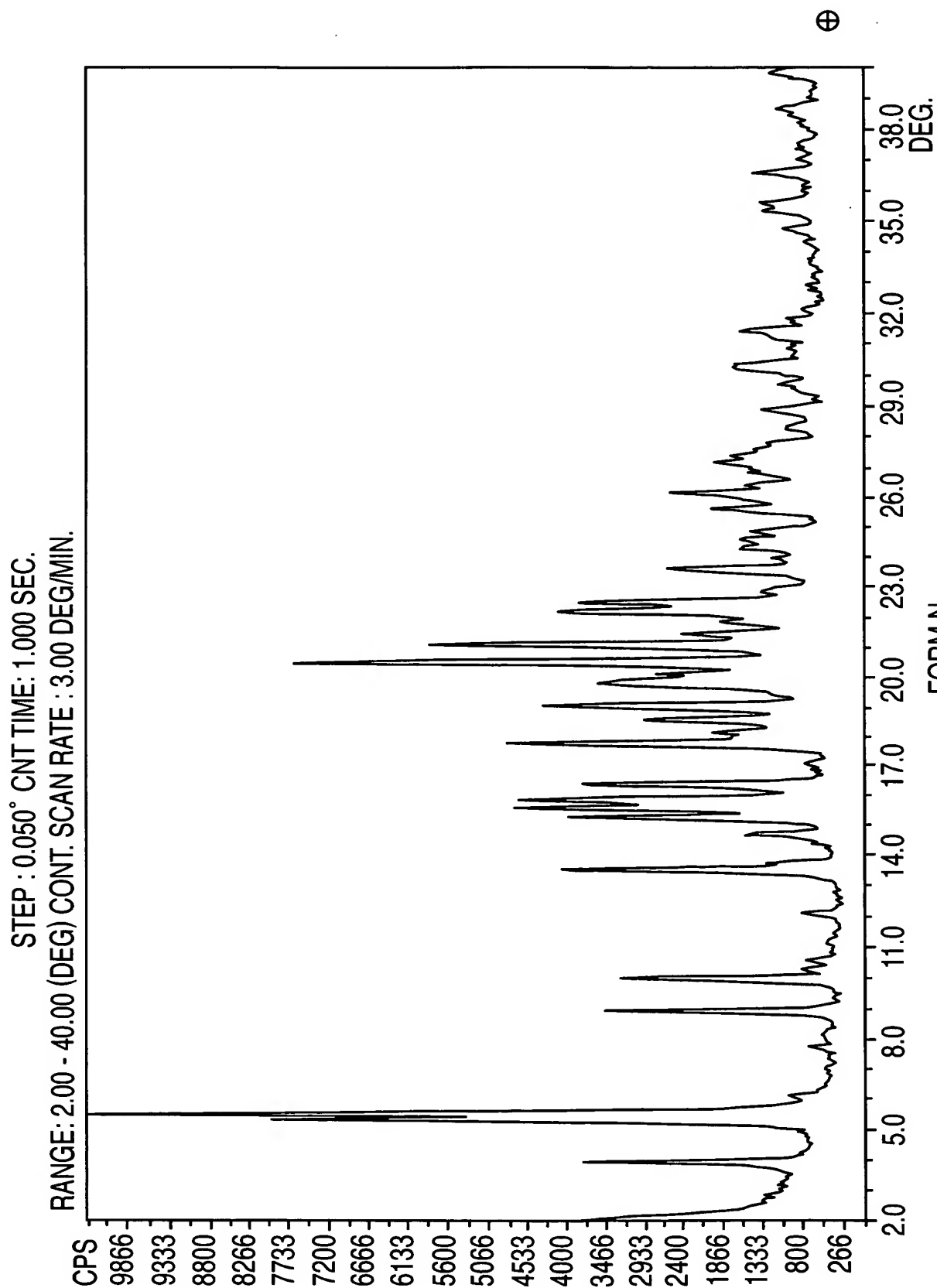
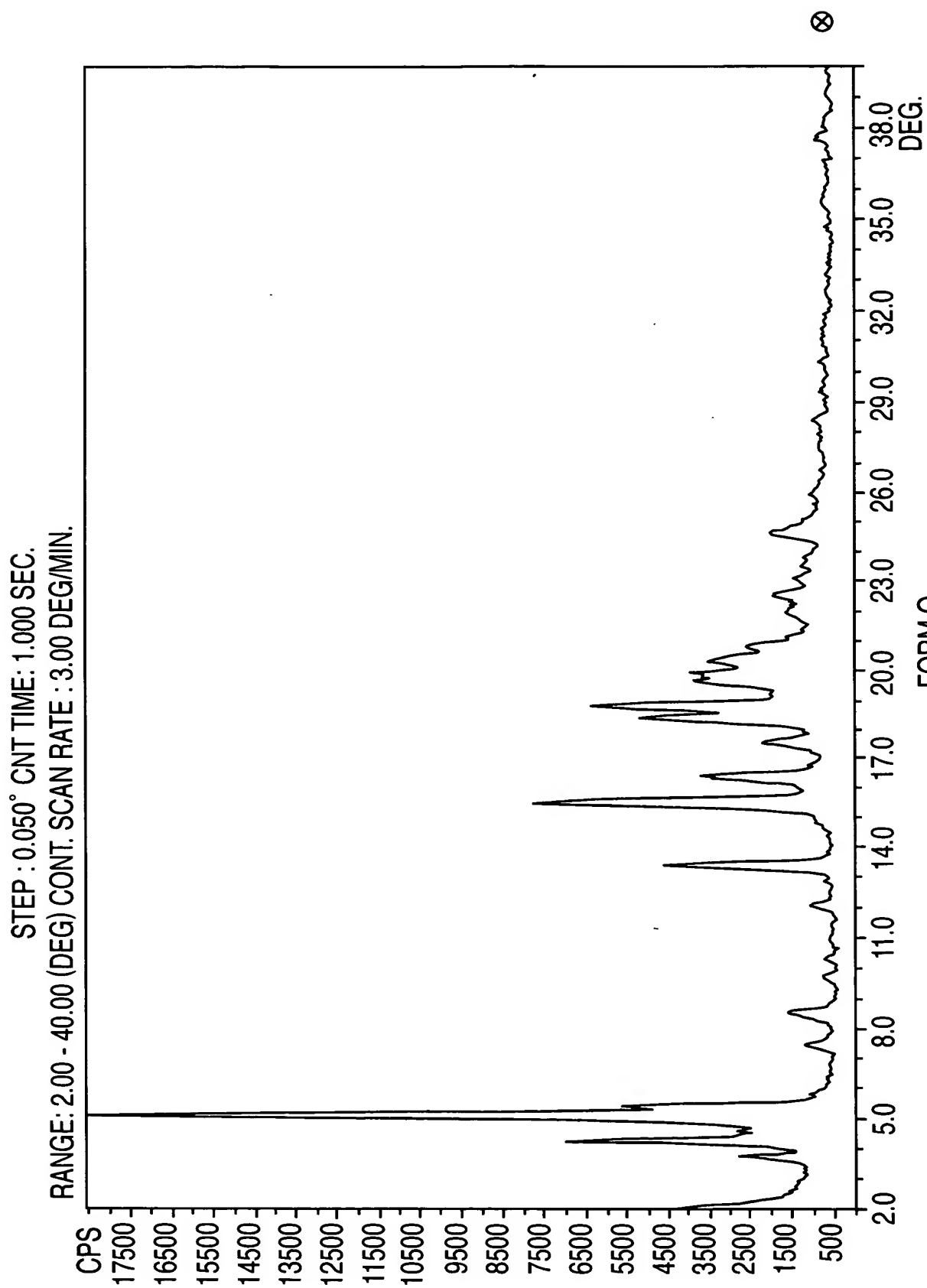
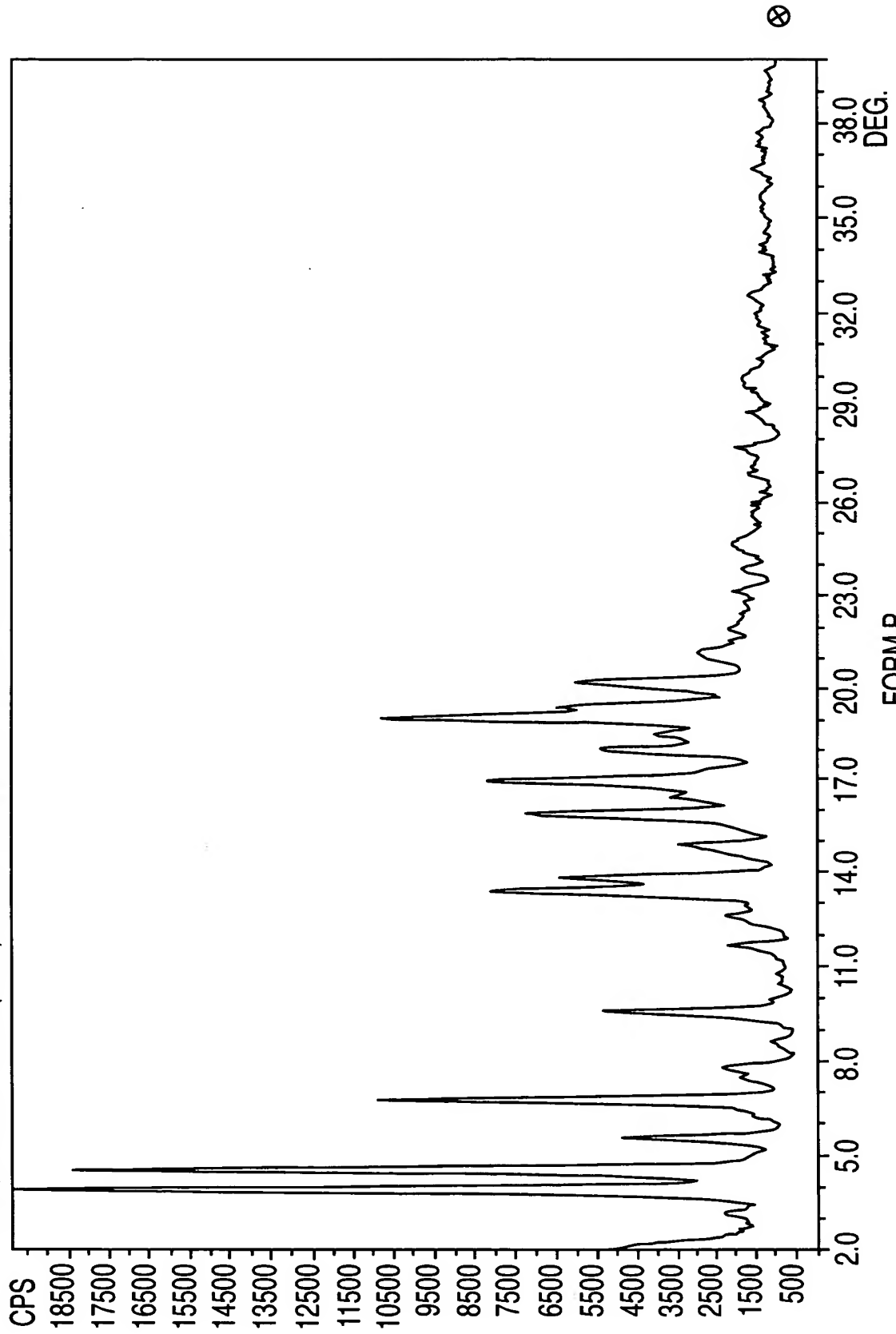


FIG. 12

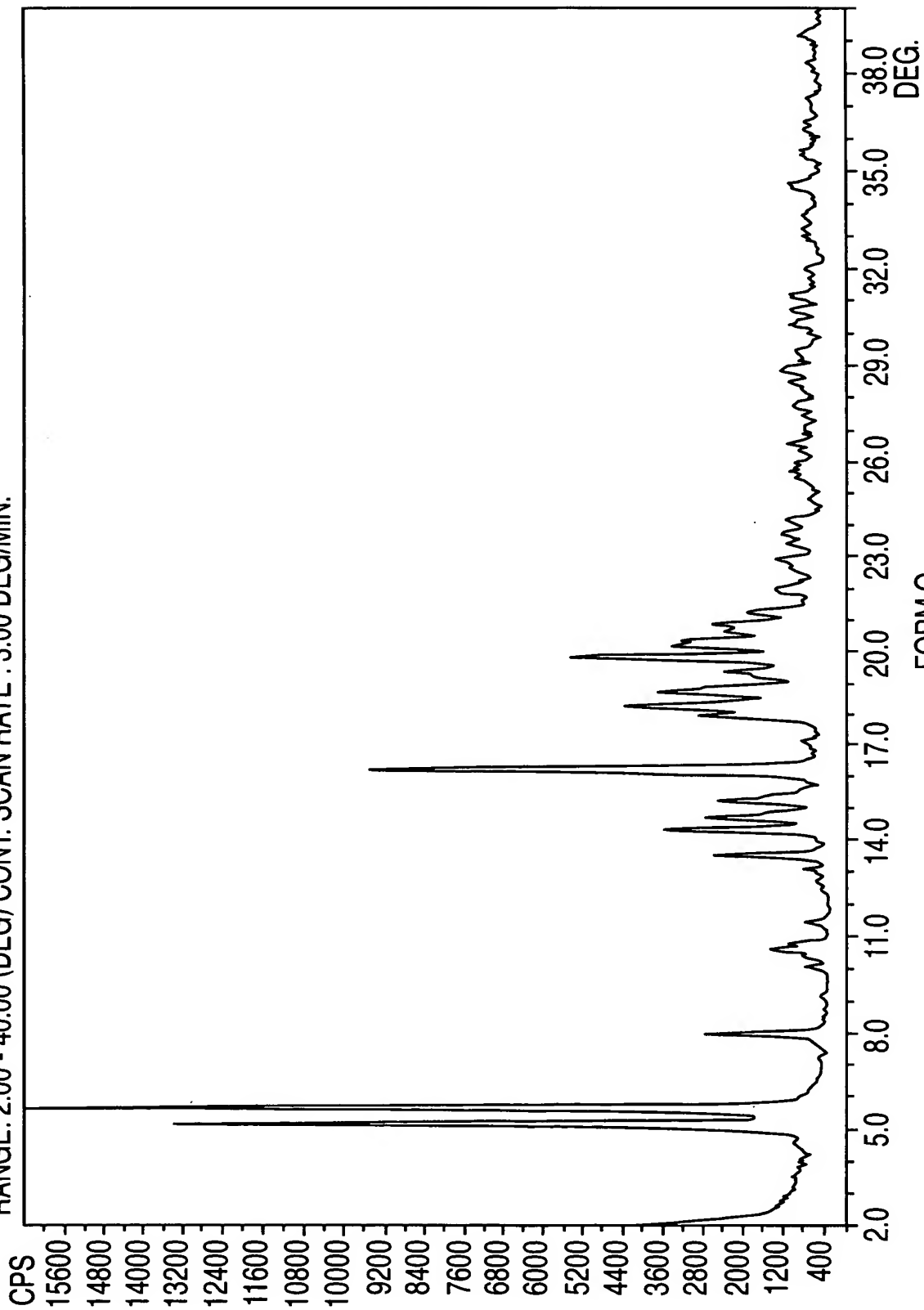


STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



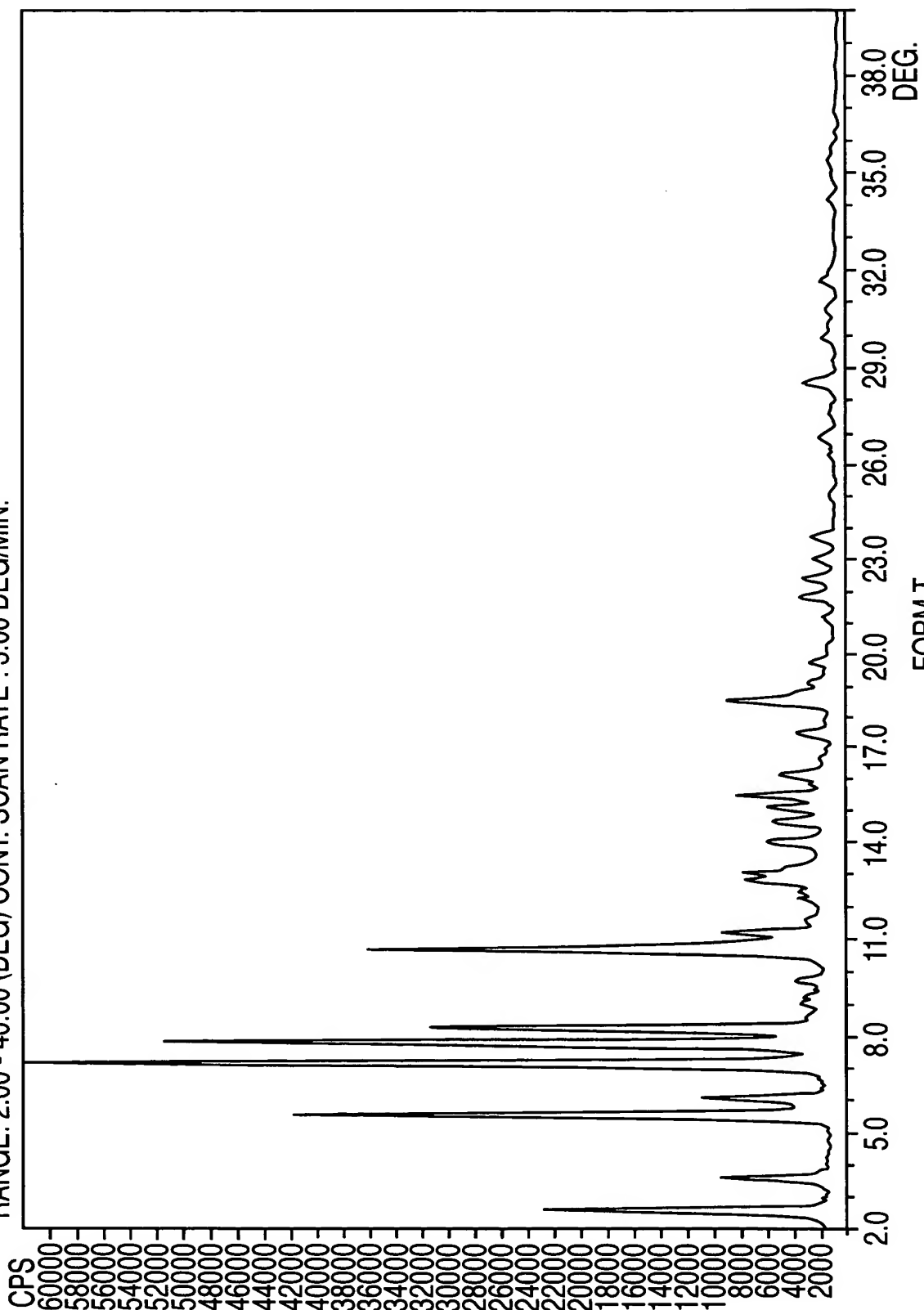
FORM P
FIG. 14

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM Q
FIG. 15

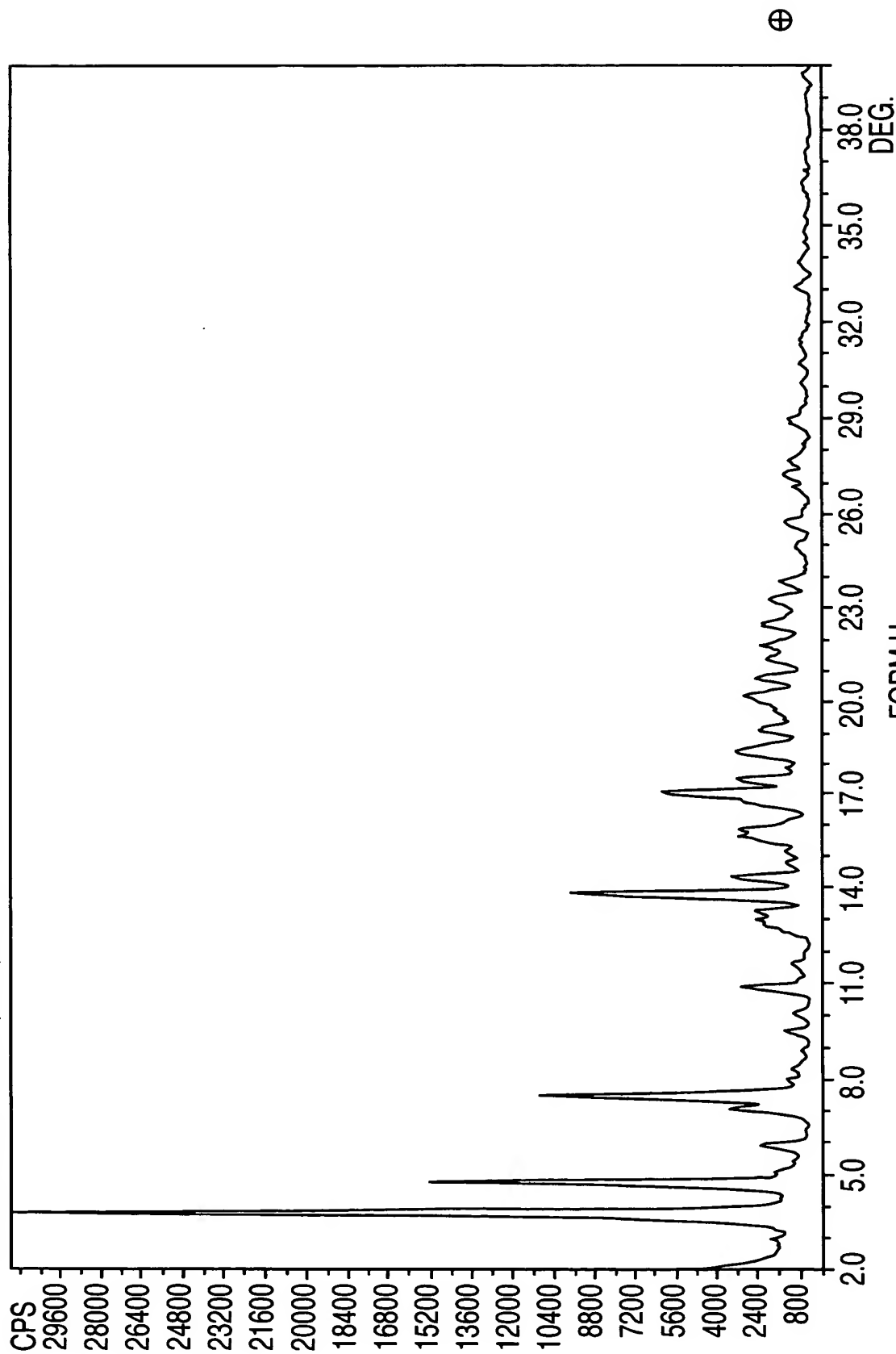
STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM T
FIG. 16

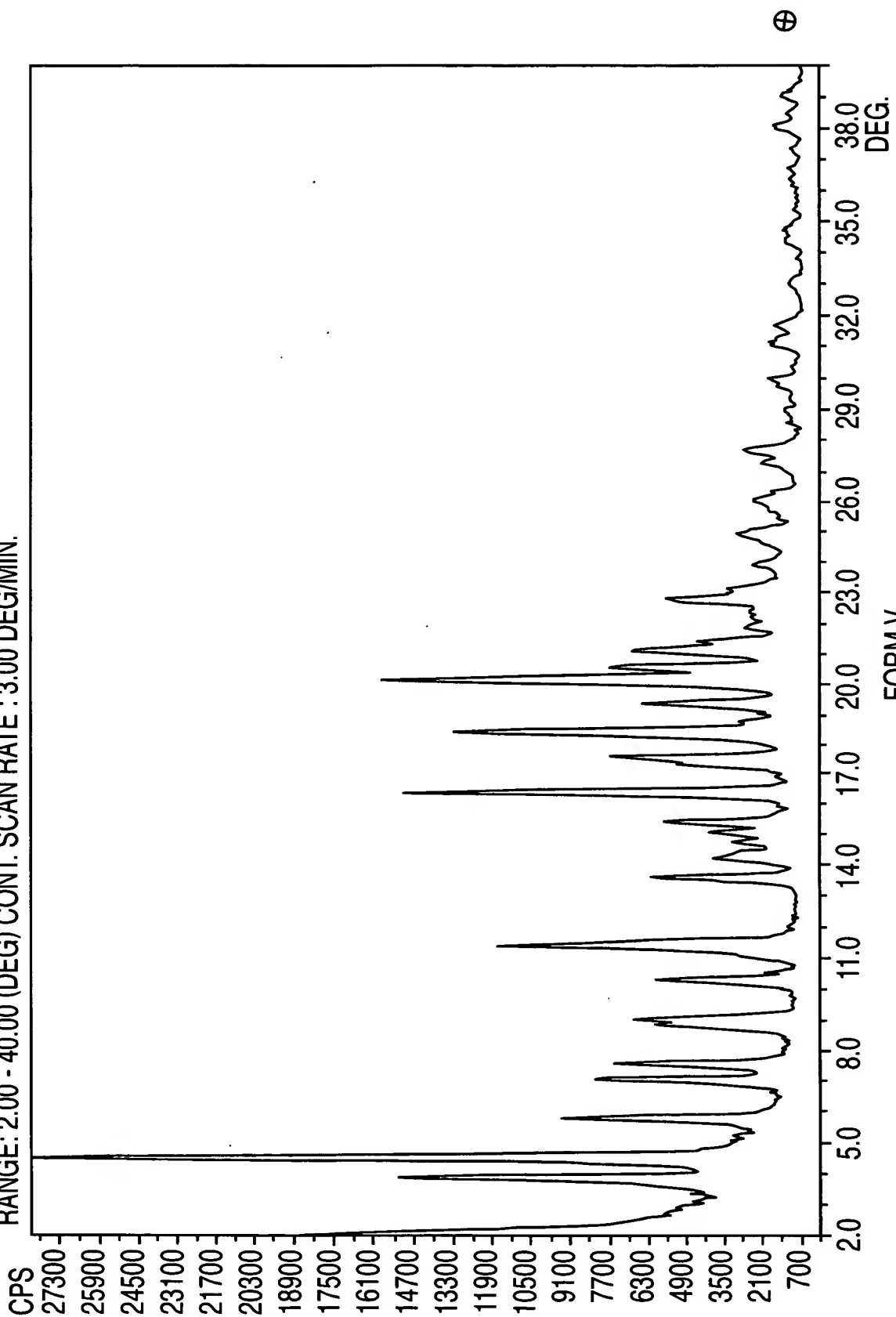
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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM U
FIG. 17

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM V

FIG. 18

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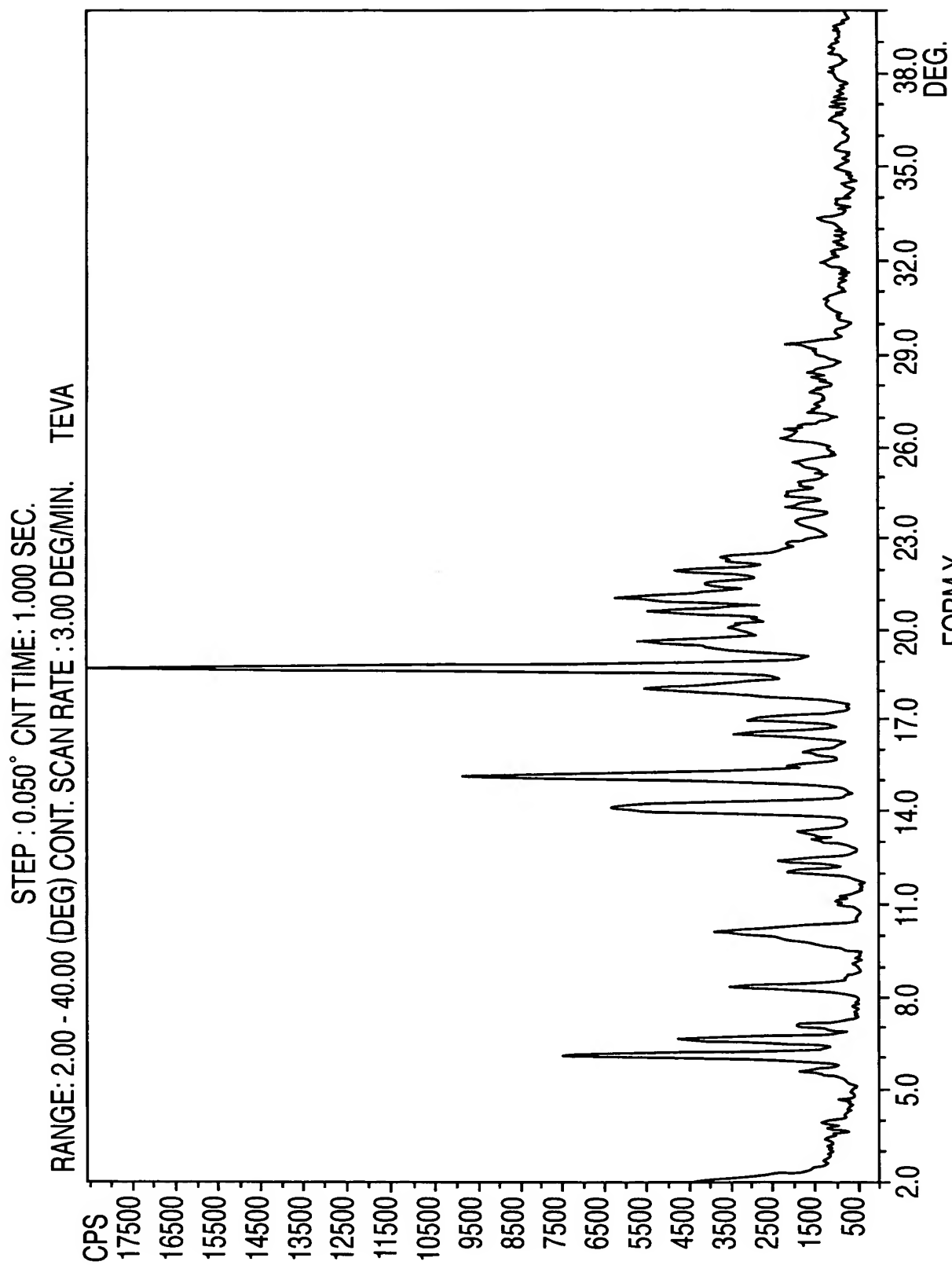
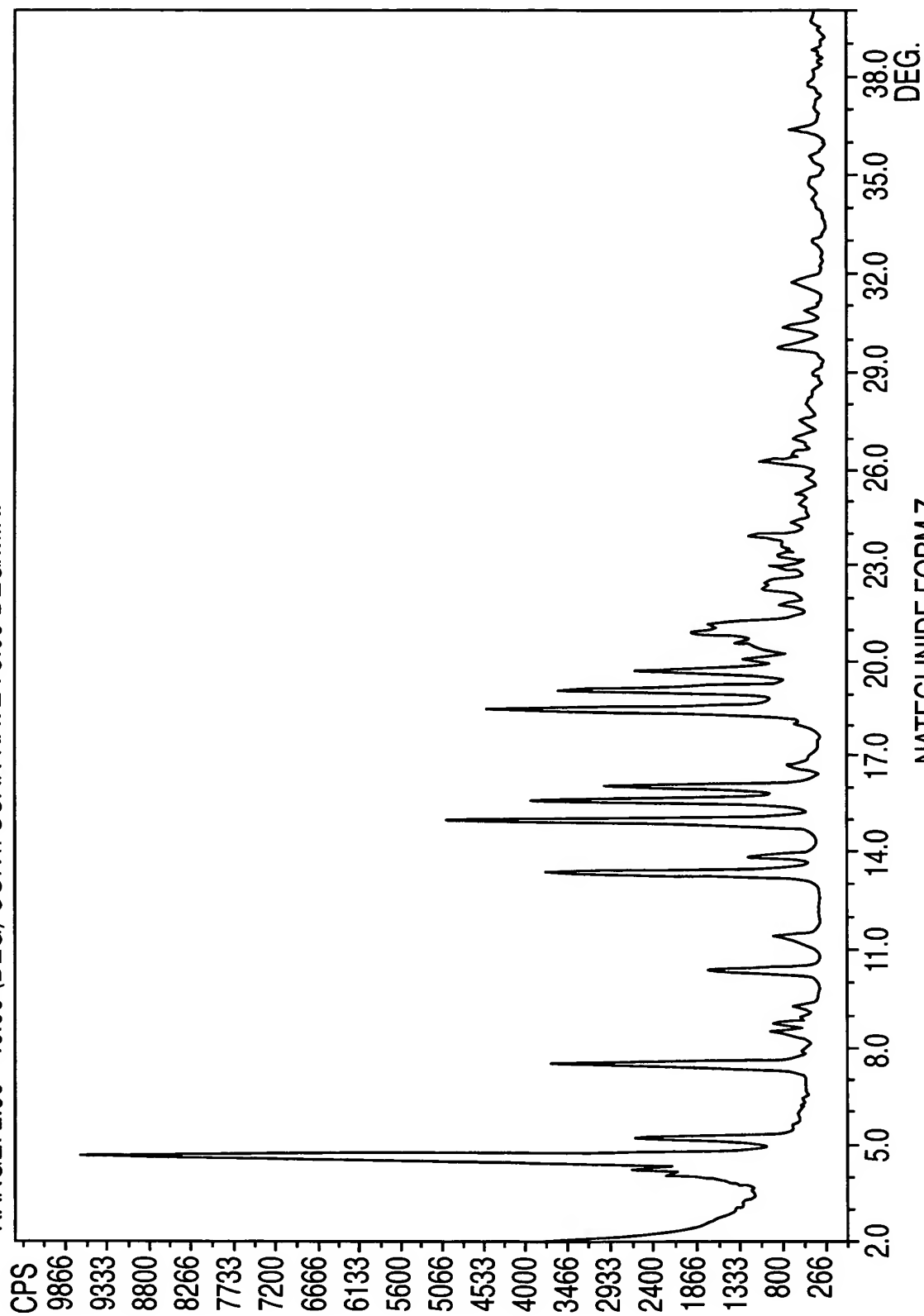


FIG. 19

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



NATEGLINIDE FORM Z

FIG. 20

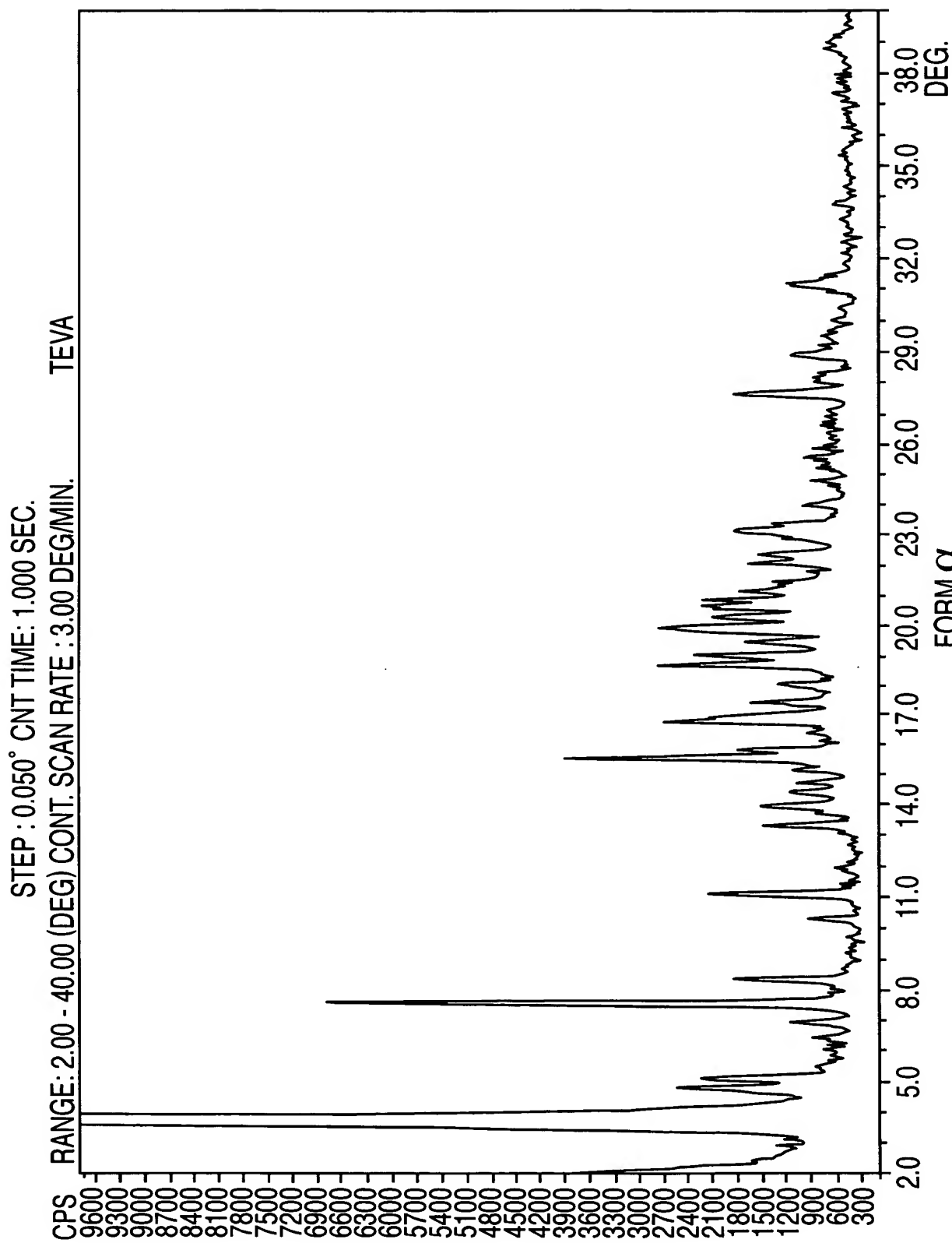
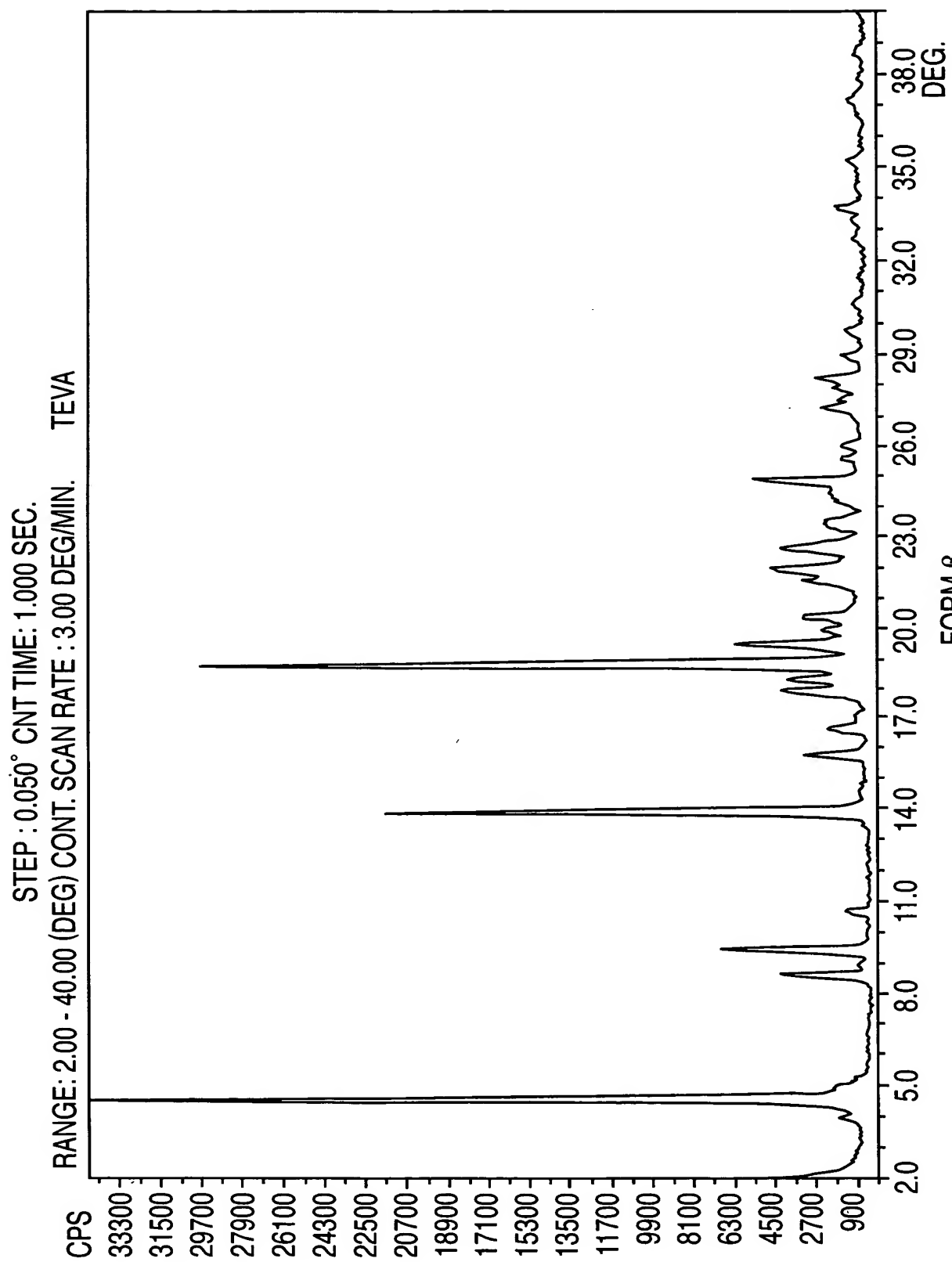


FIG. 21



FORM β

FIG. 22

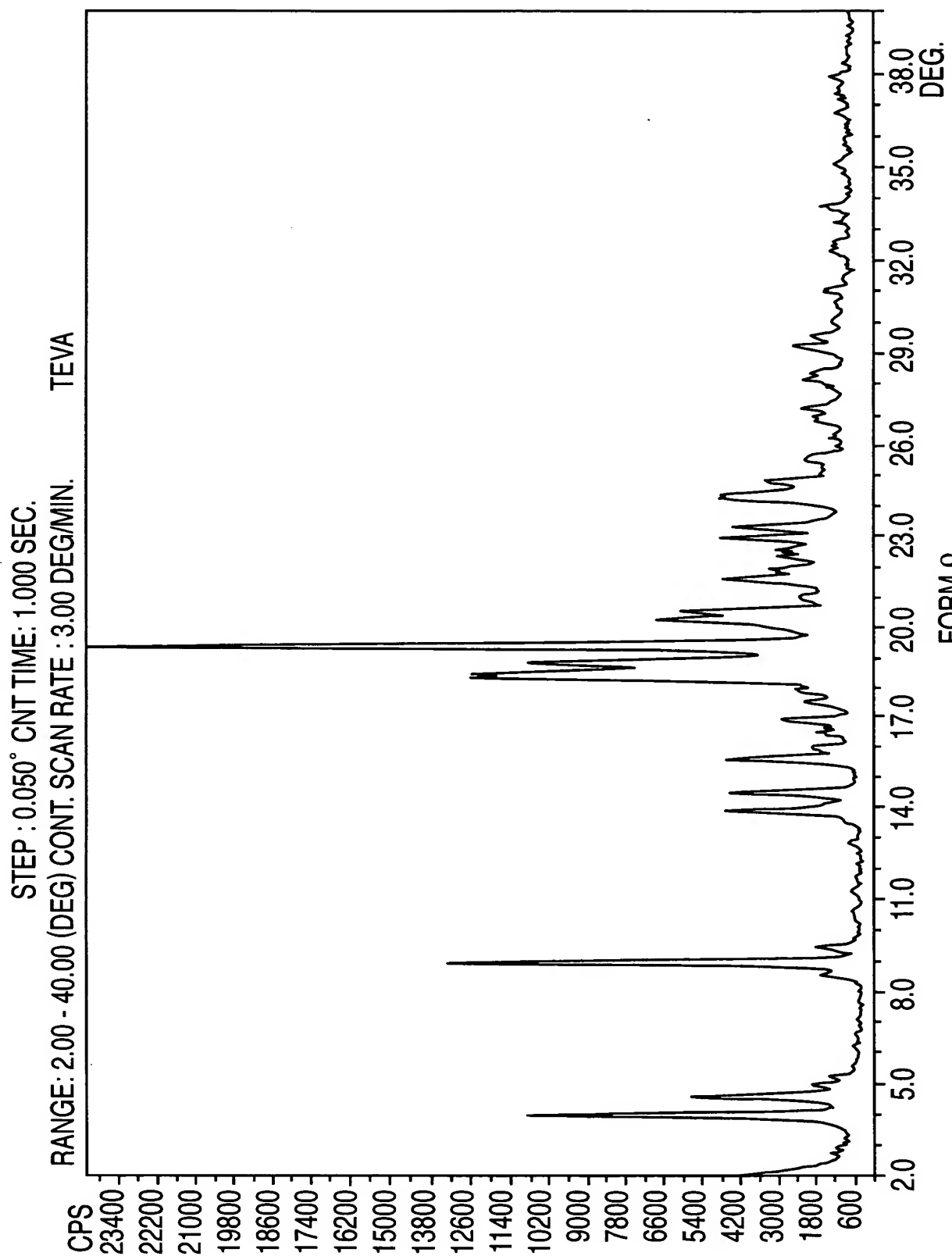
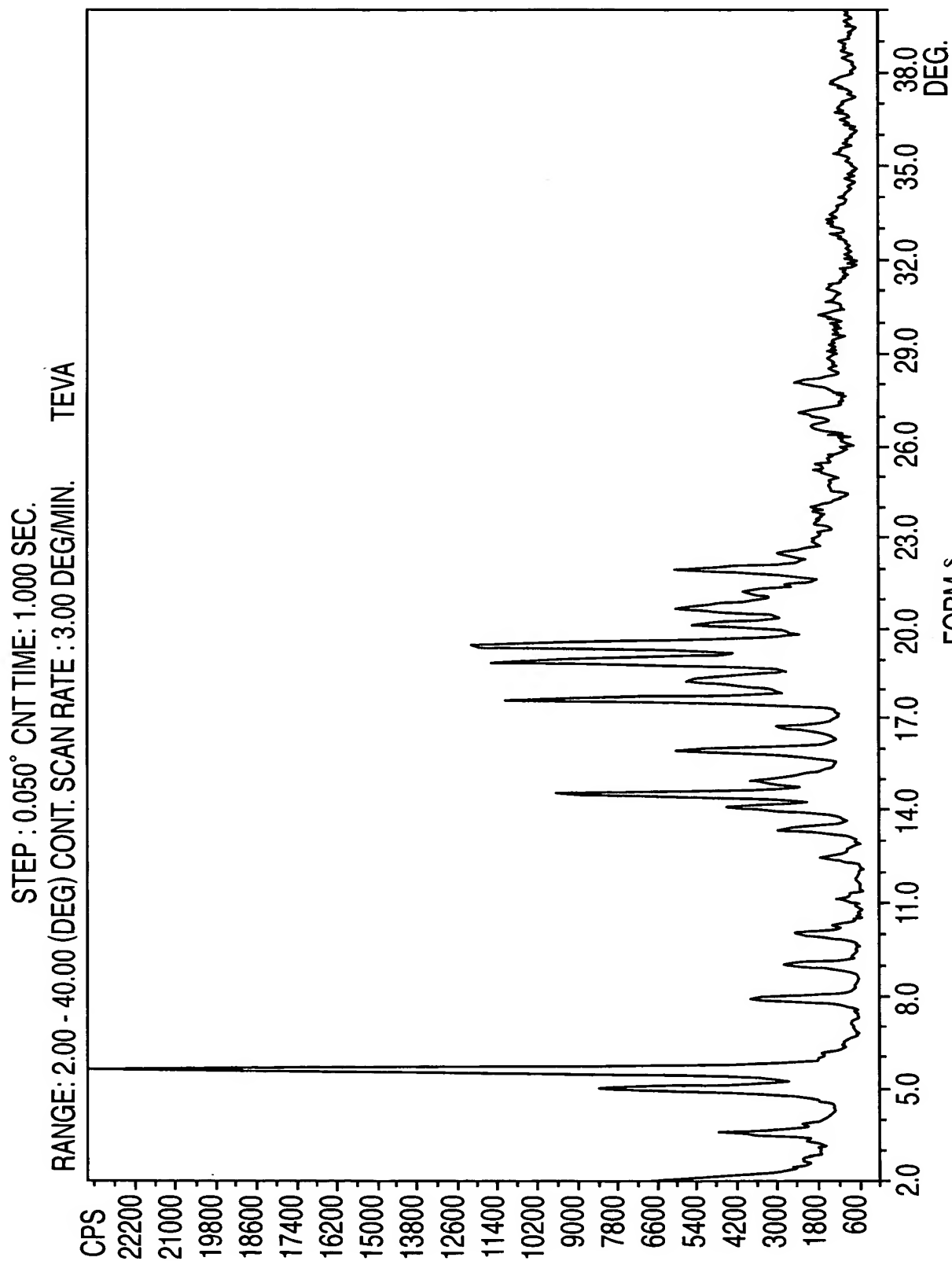


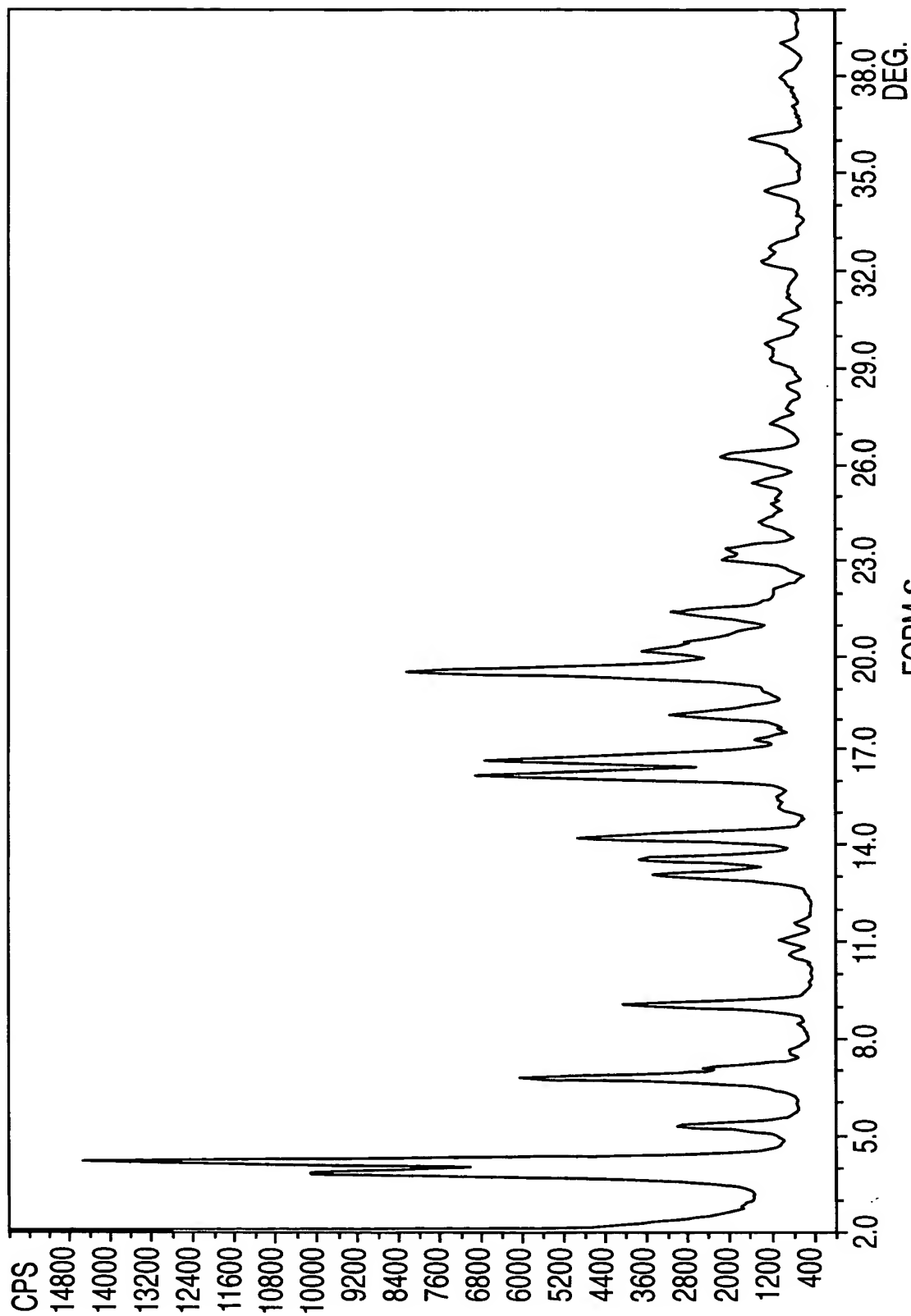
FIG. 23



FORM 8

FIG. 24

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN. TEVA



FORM 8

FIG. 25

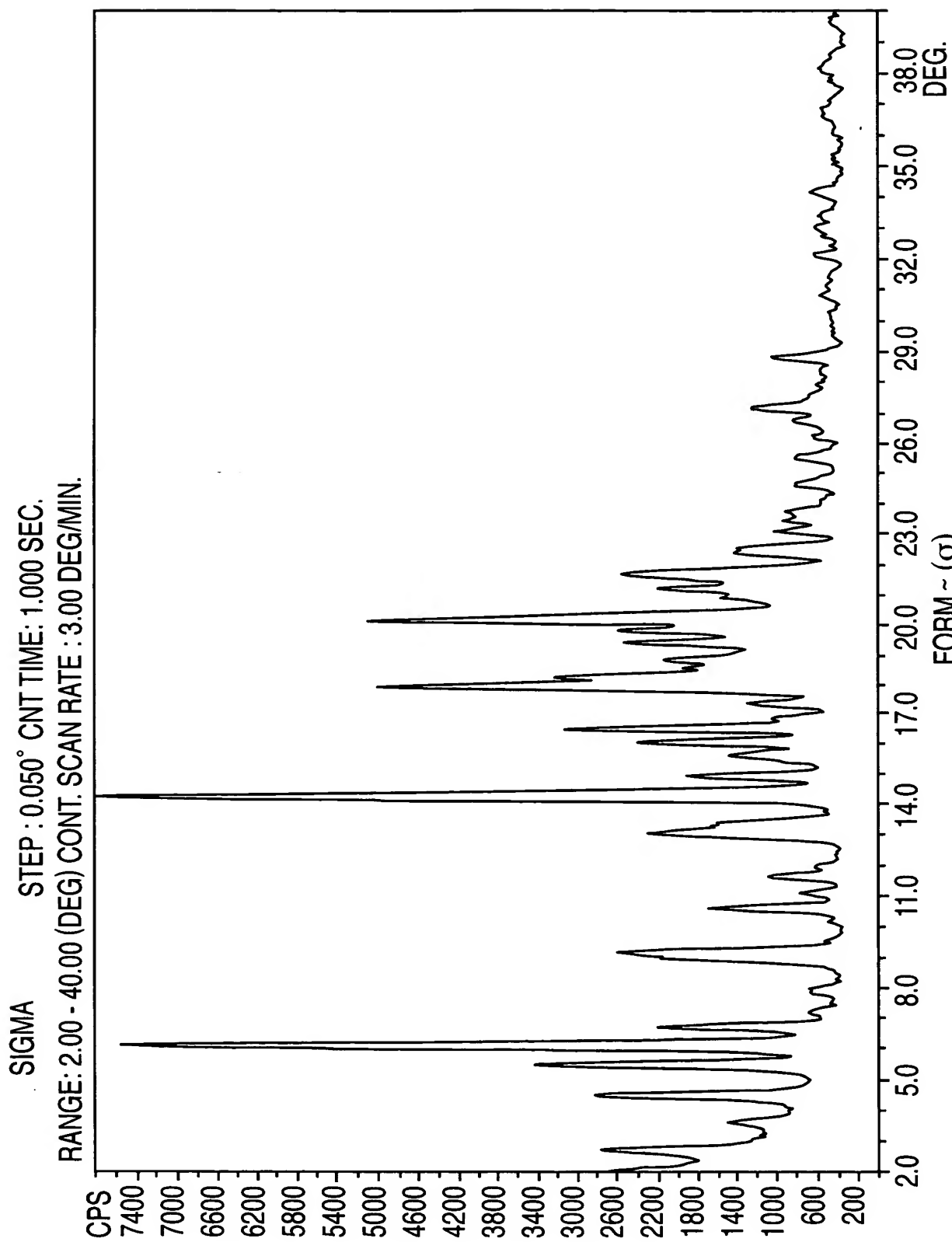
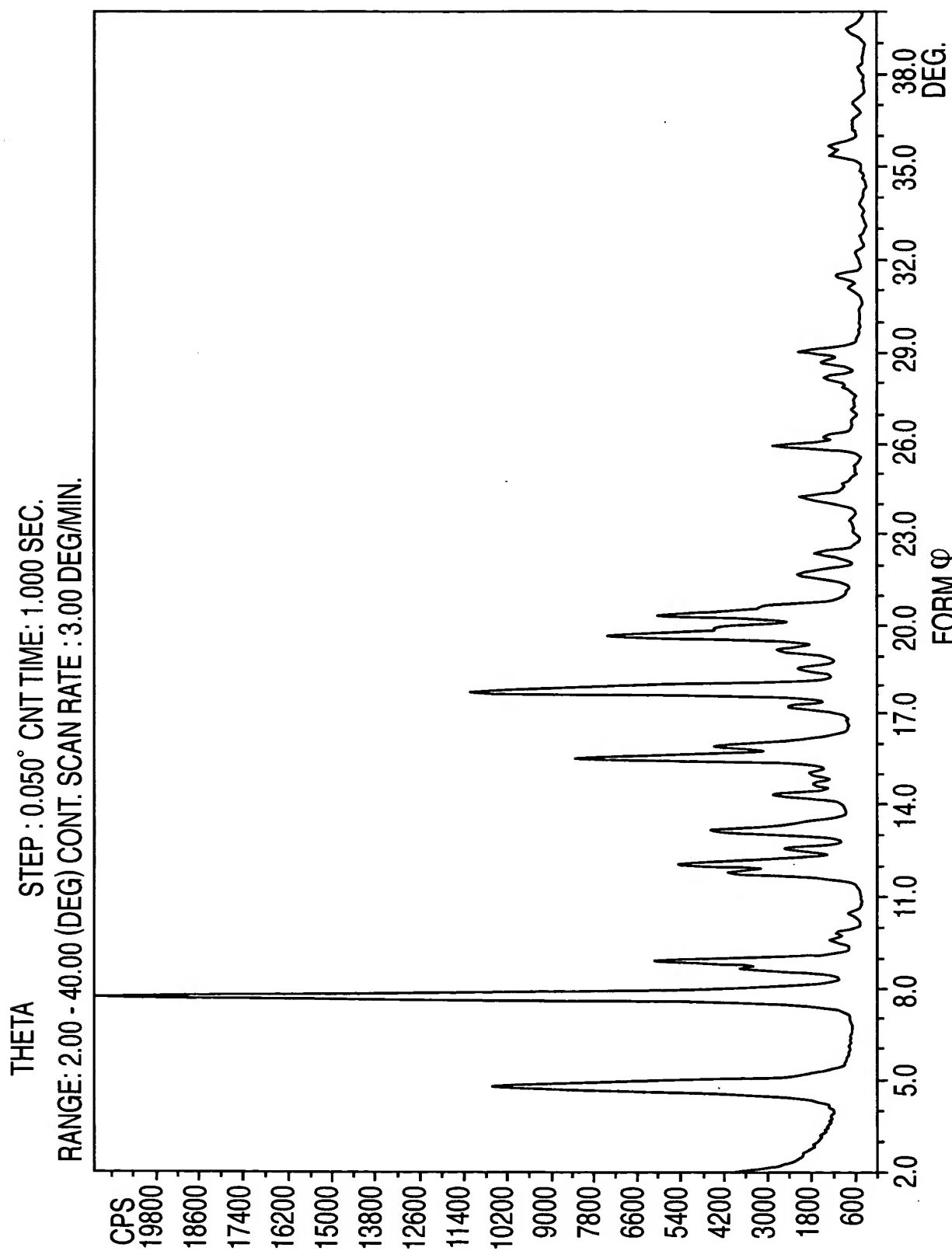
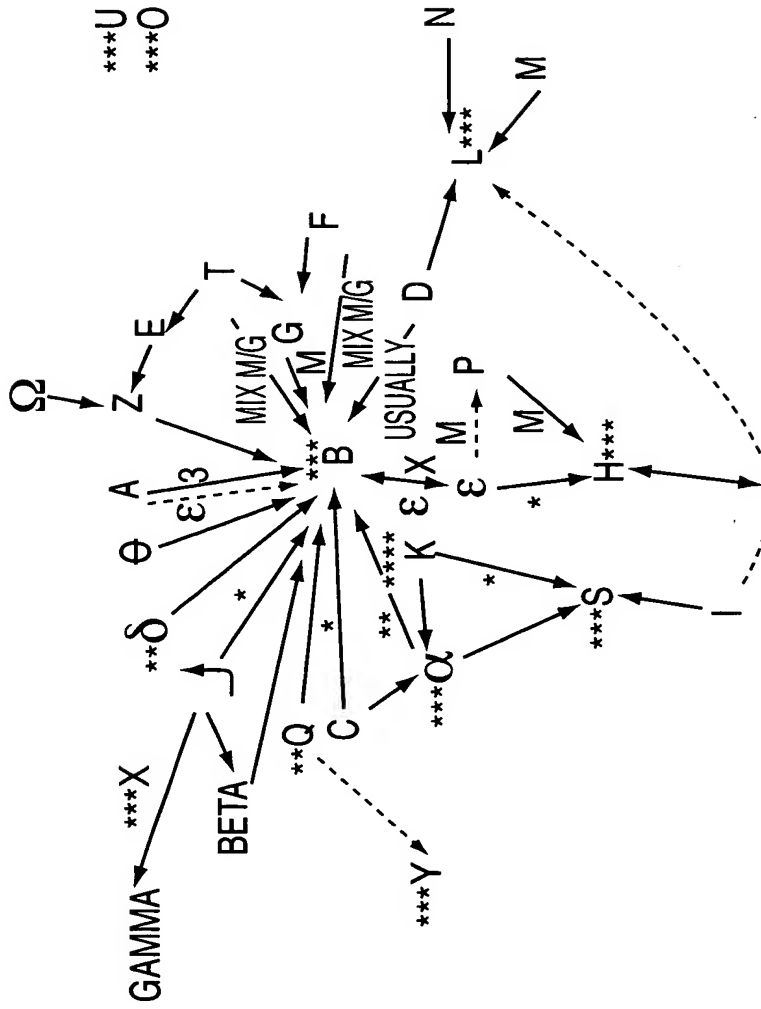


FIG. 26



FORM φ

FIG. 27



* TRANSFORMATION MAY PROCEED THROUGH ANOTHER TERM.

** THERMALLY STABLE AT LOWER HEATING TEMPERATURES (~50°C).

*** THERMALLY STABLE FORMS.

--- TRANSFORMATION AFTER STORAGE AT ROOM TEMPERATURE.

m MIXTURE WITH STARTING FORM.

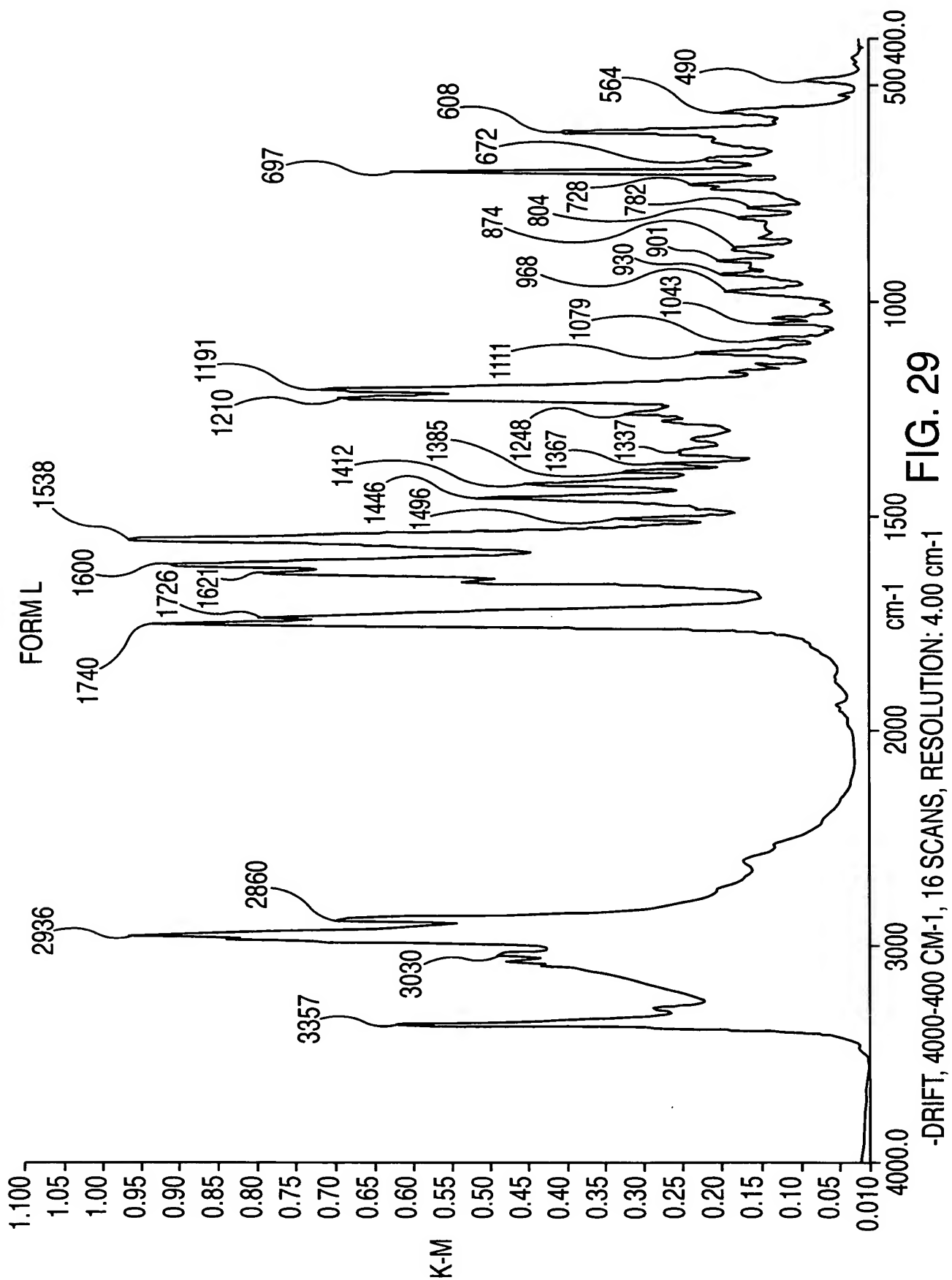
**** WHEN STARTING MATERIAL CONTAINS SEEDS.

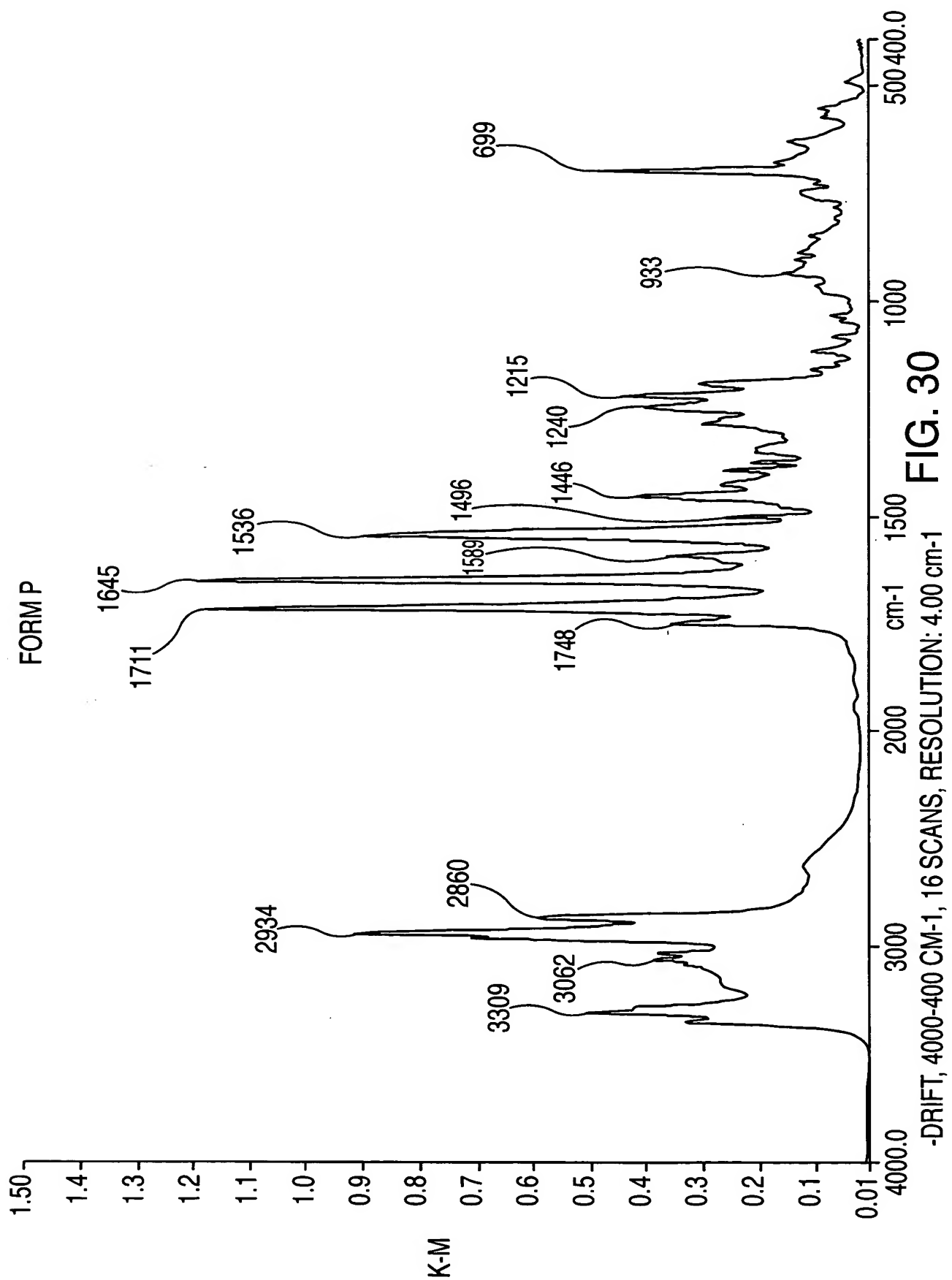
sol RESULTS MIGHT VARY DEPENDING ON THE SOLVATE OF FORM EPSILON USED.

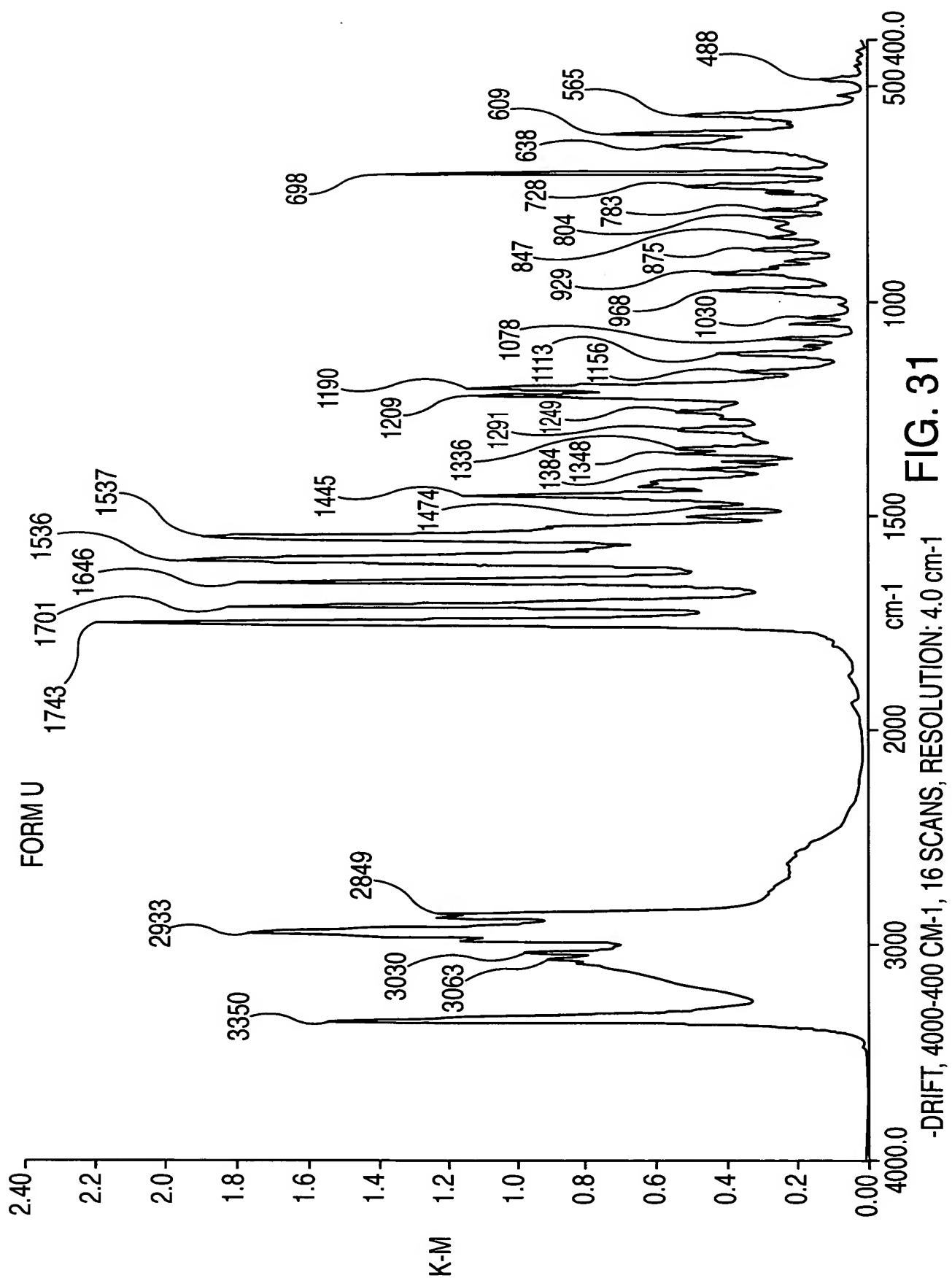
THERMAL STABILITY CHART

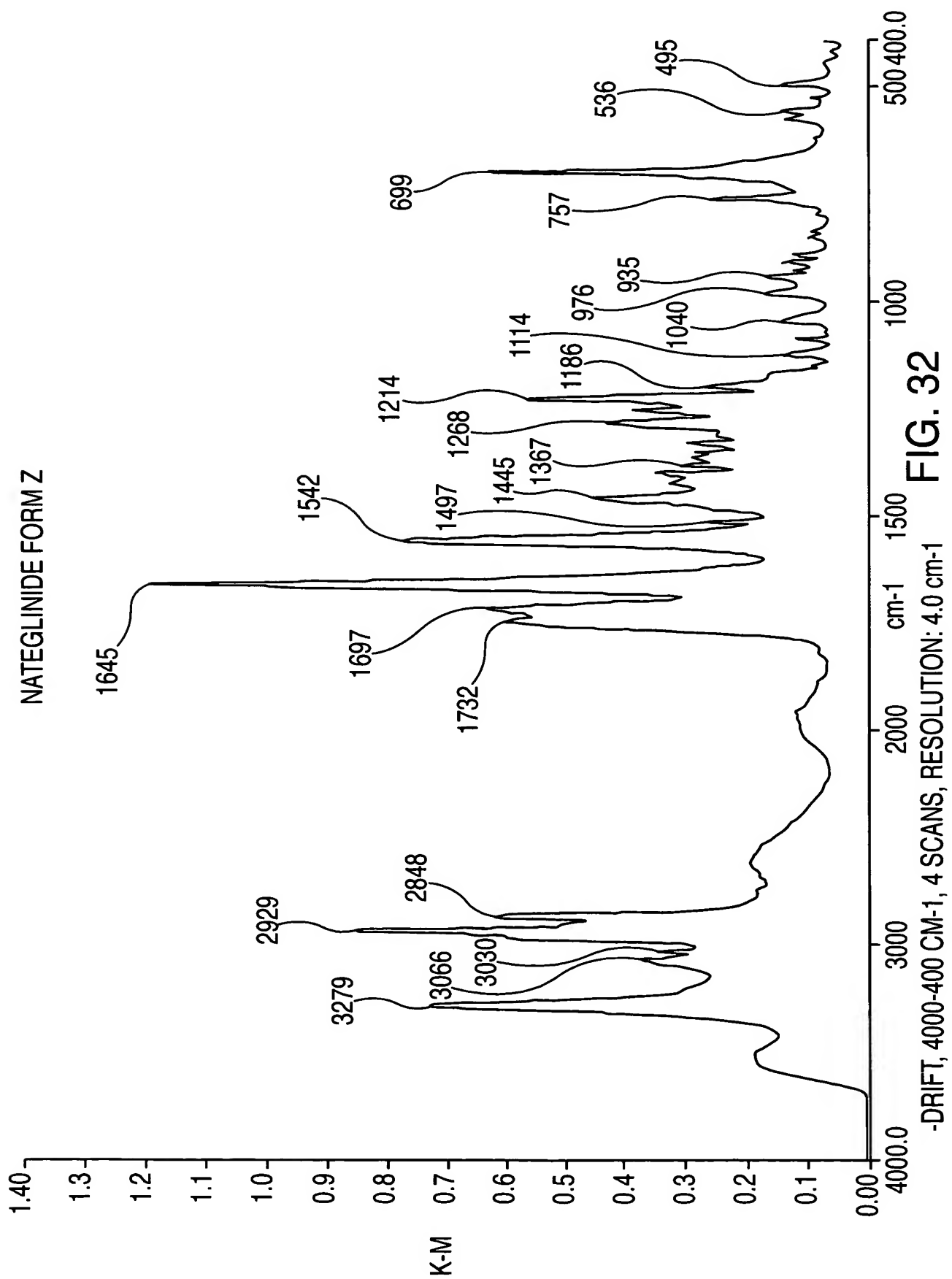
FIG. 28

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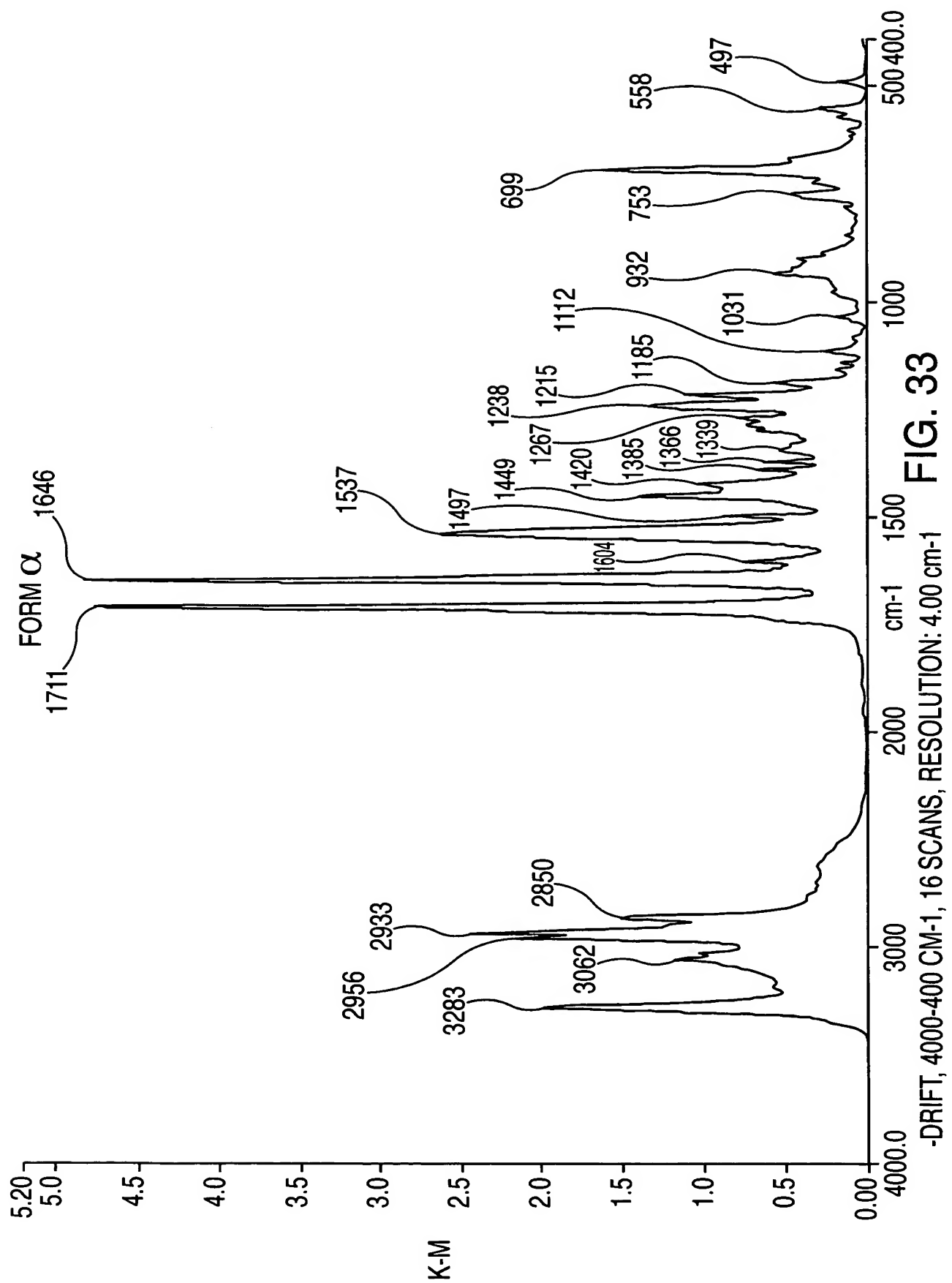
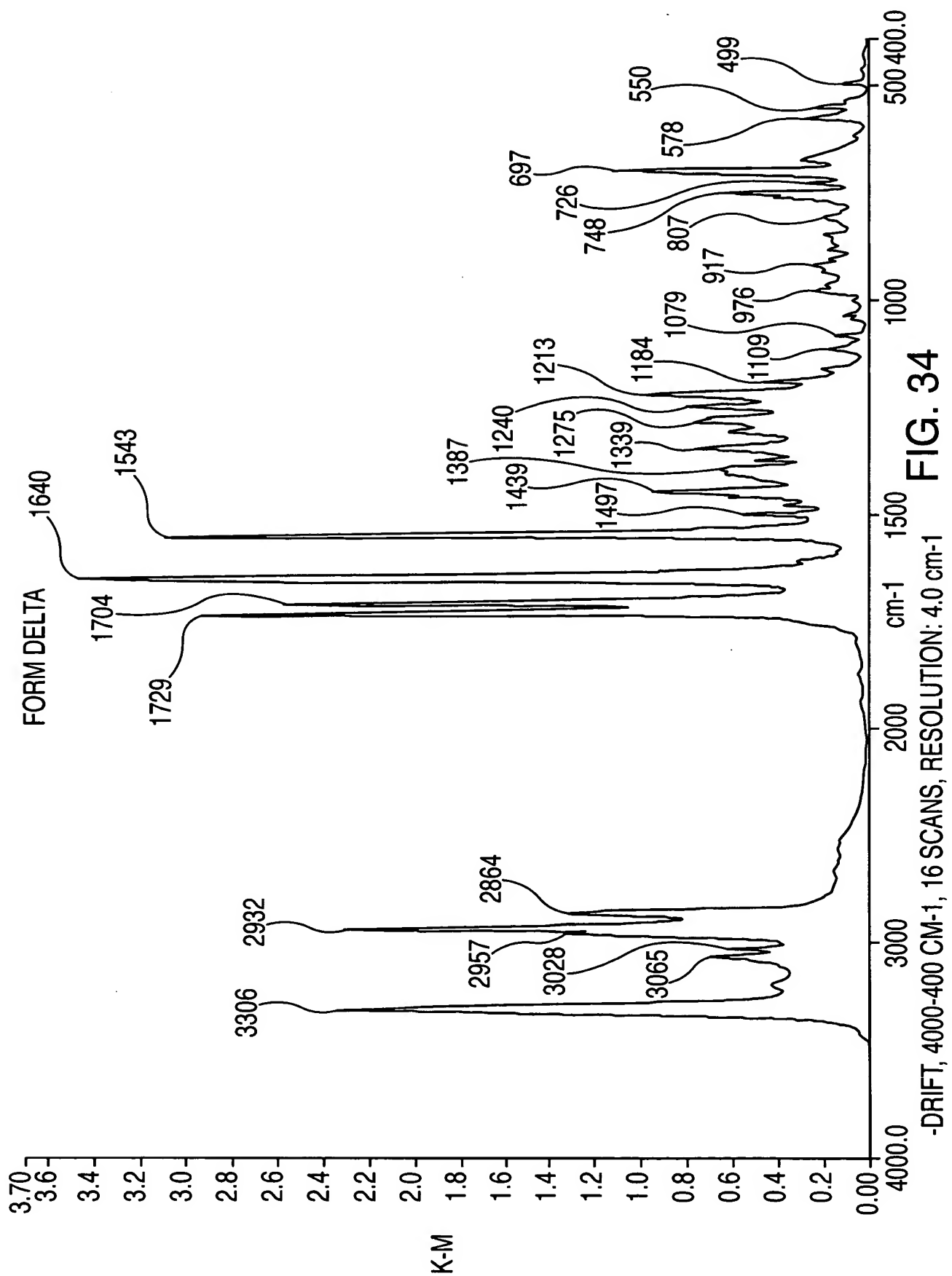
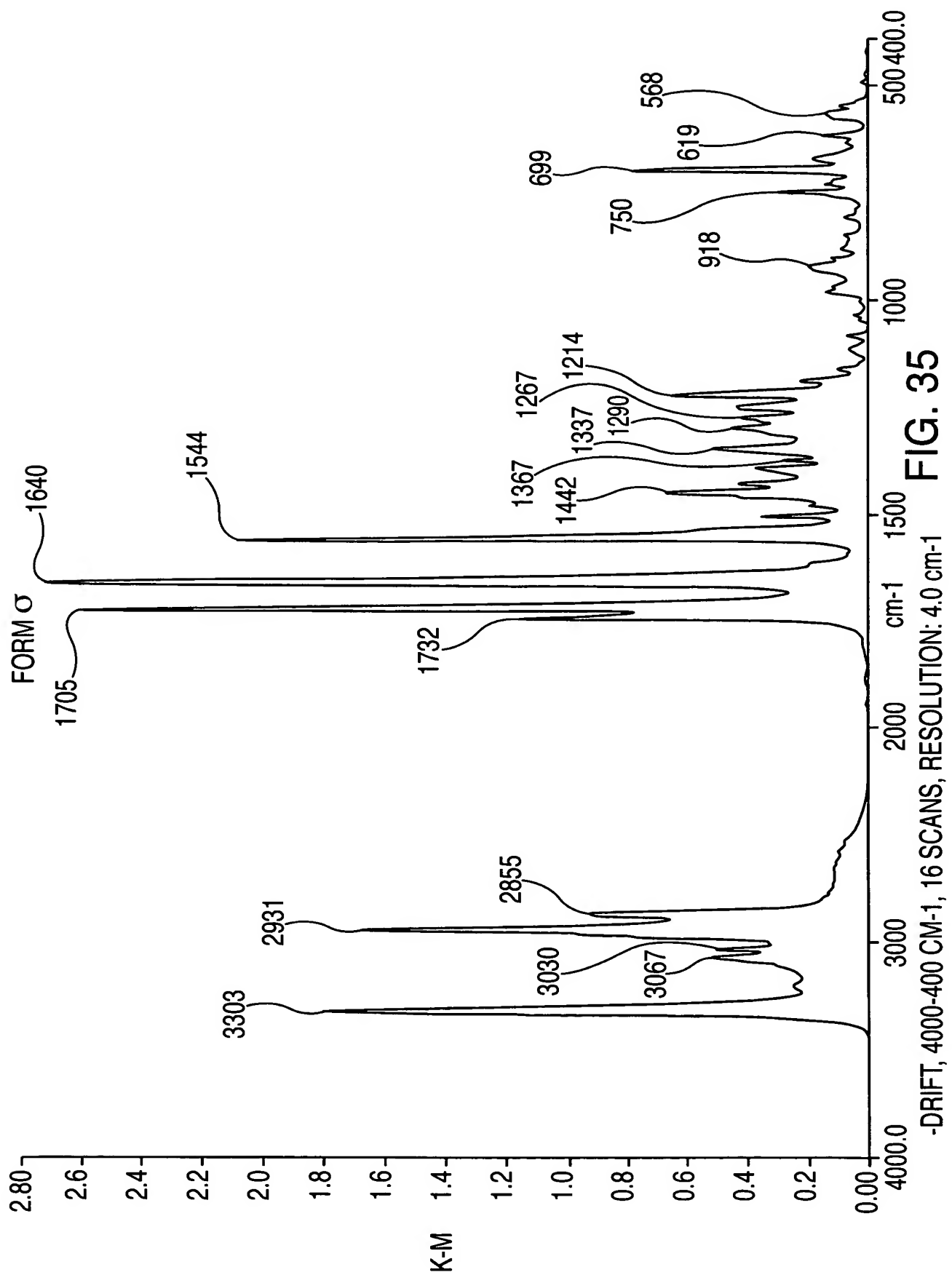
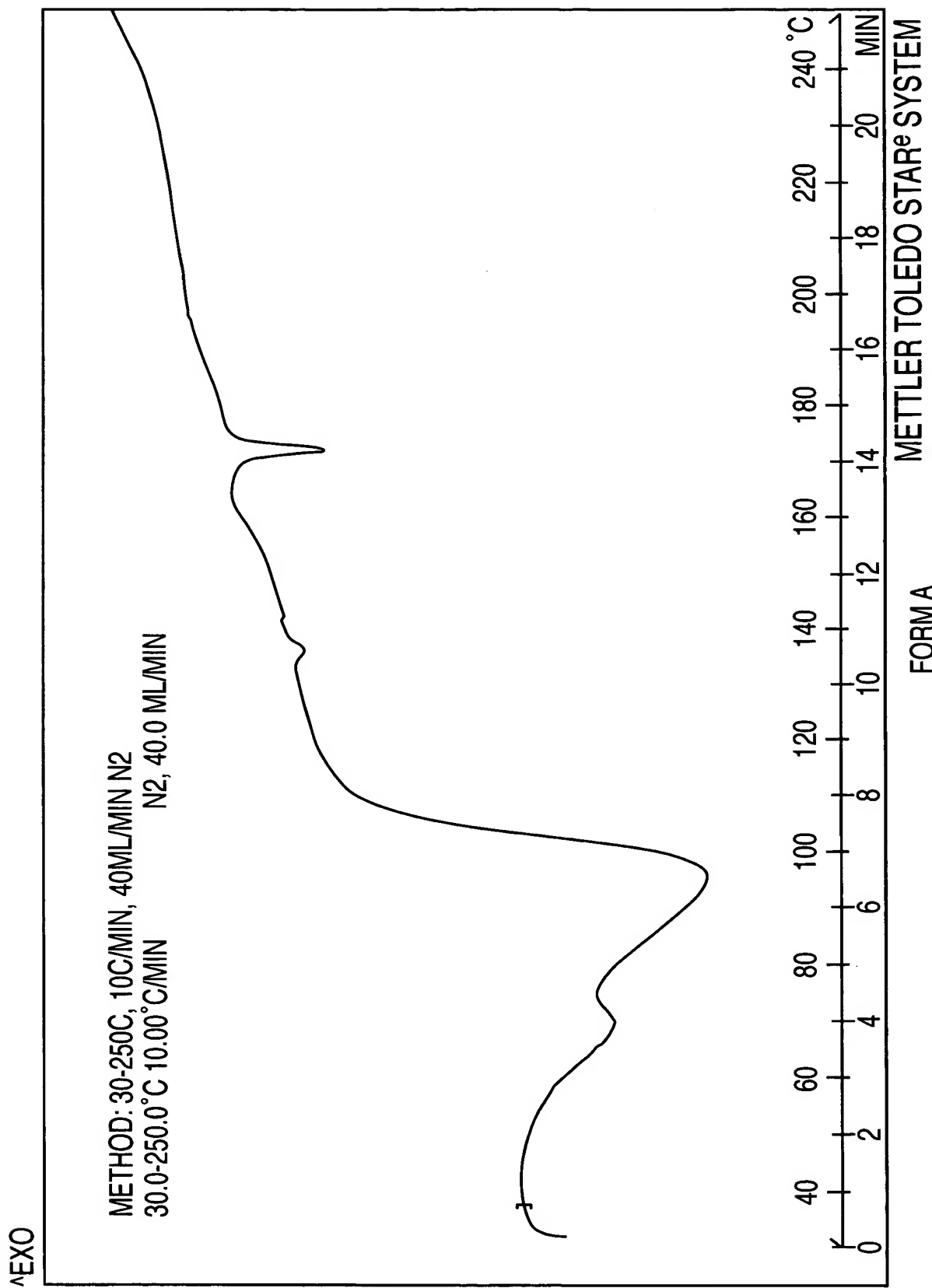


FIG. 33







FORM A
FIG. 36

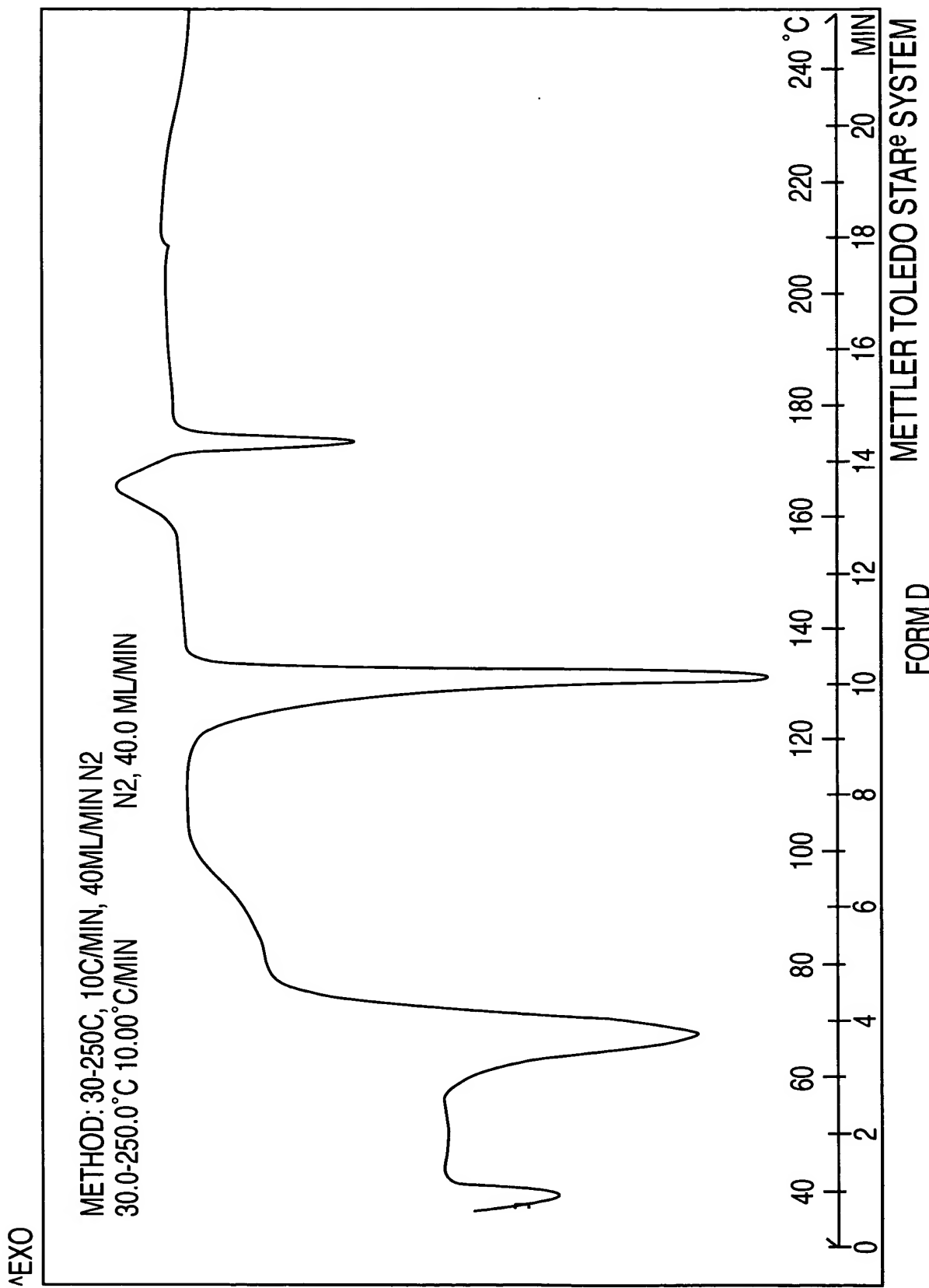
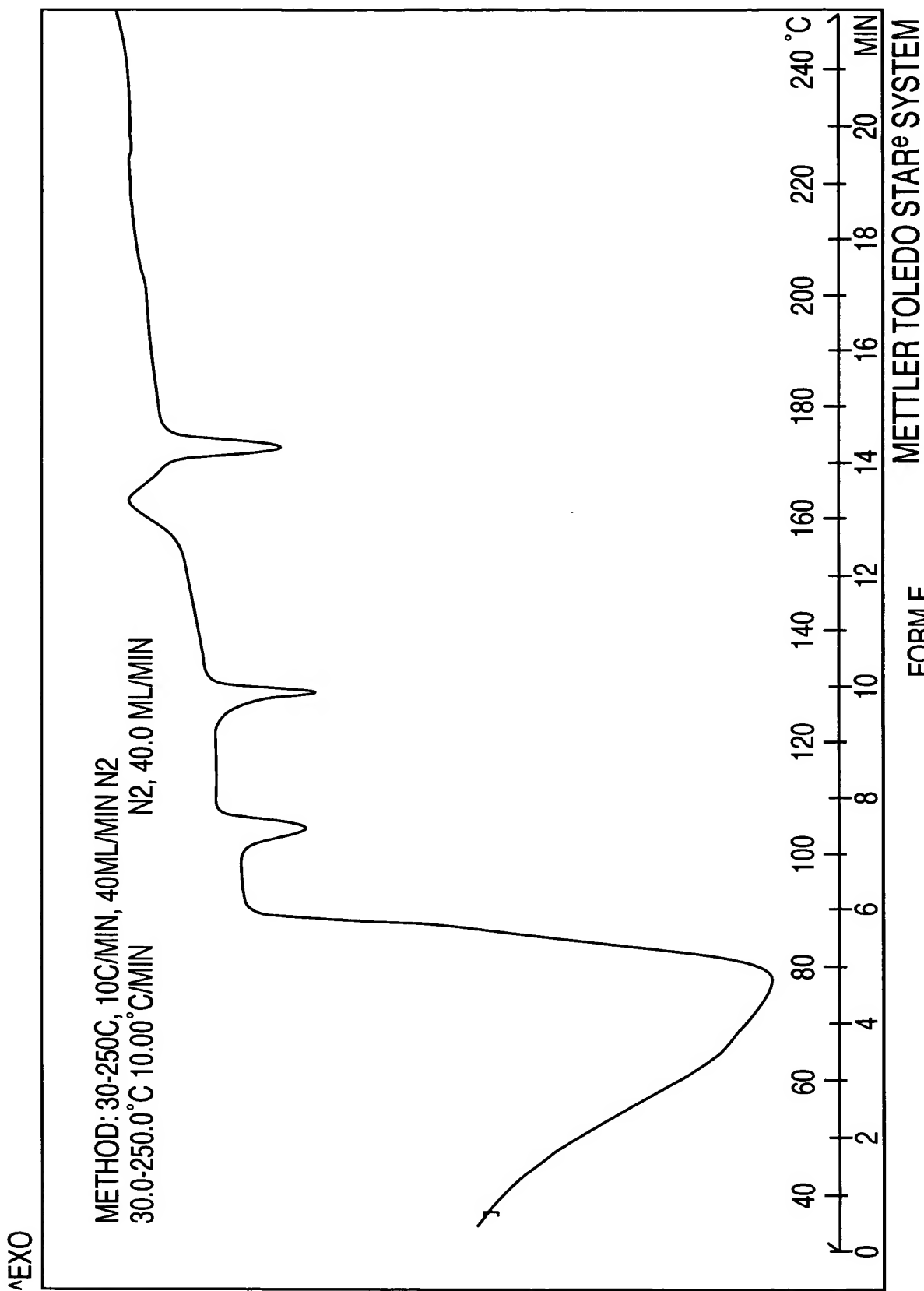


FIG. 37



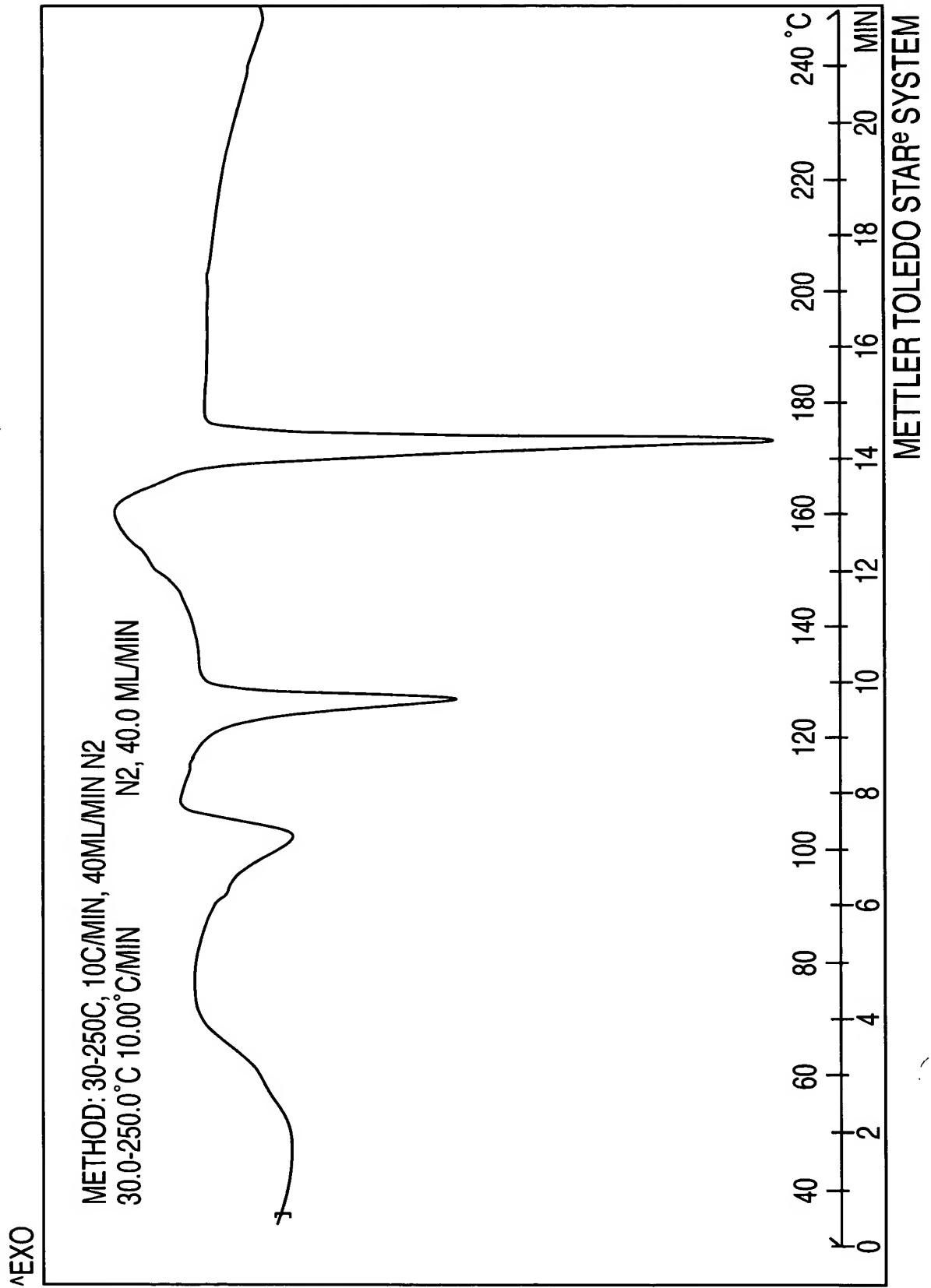


FIG. 39

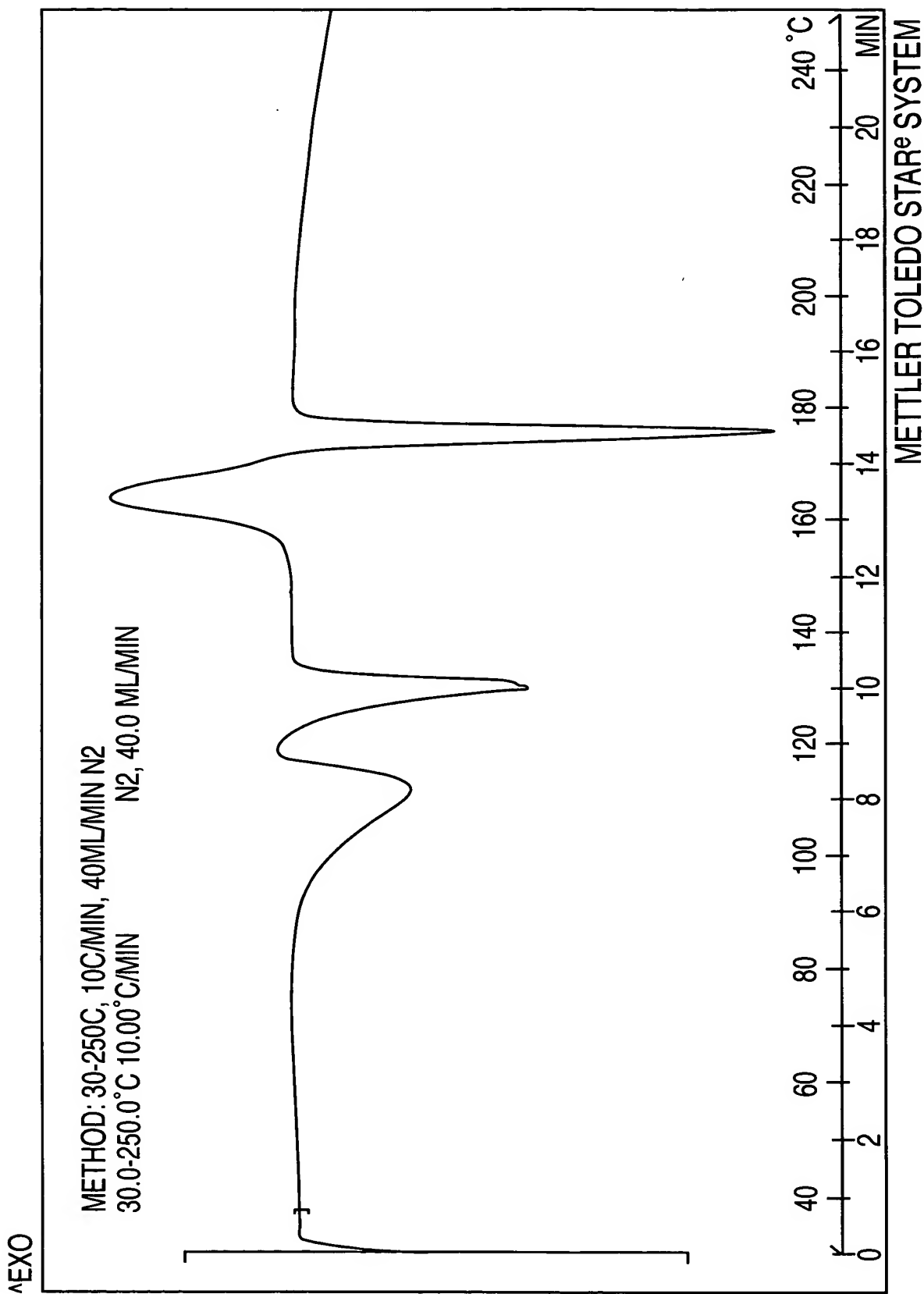
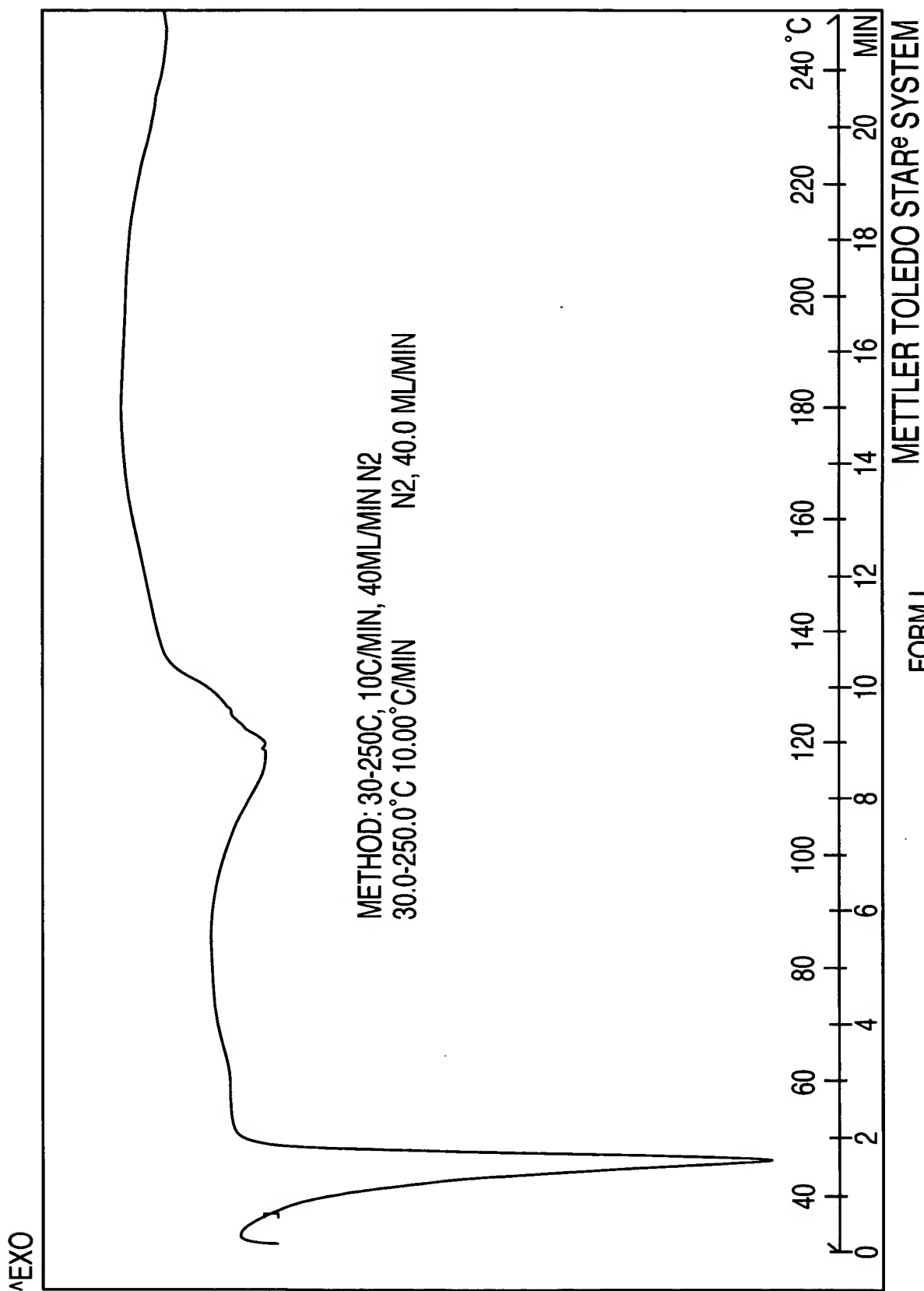


FIG. 40



FORM I

FIG. 41

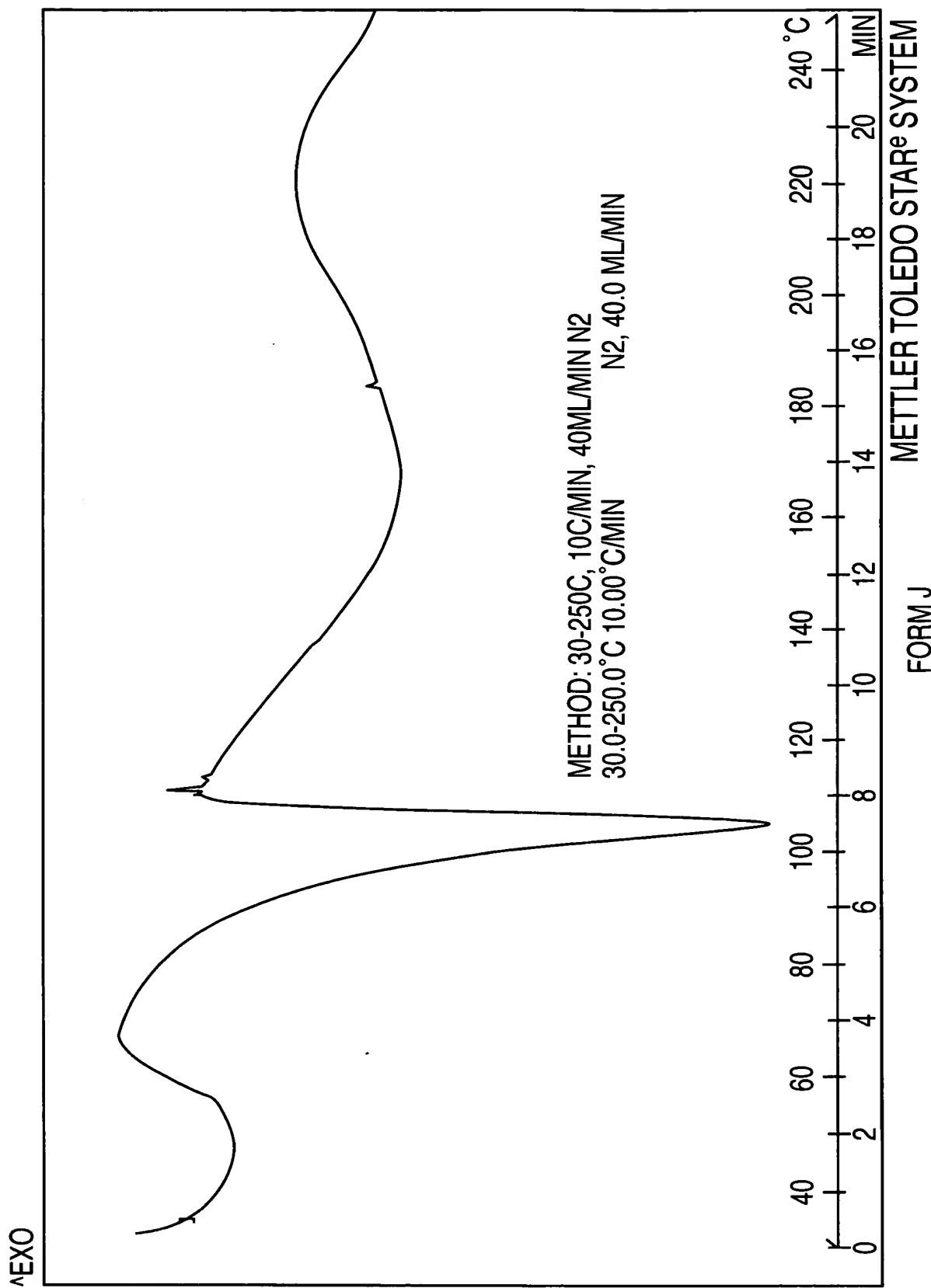
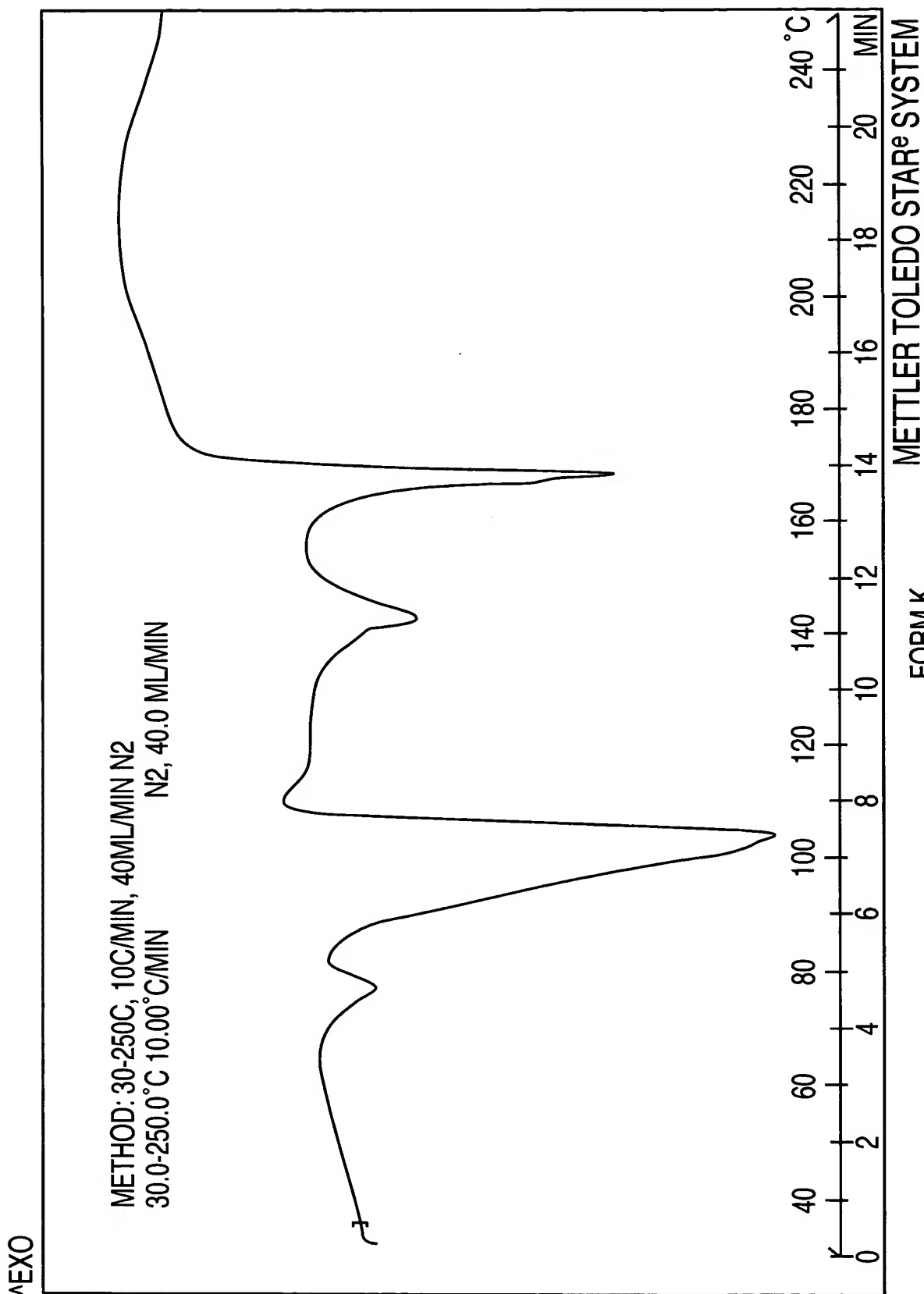


FIG. 42



FORM K
FIG. 43

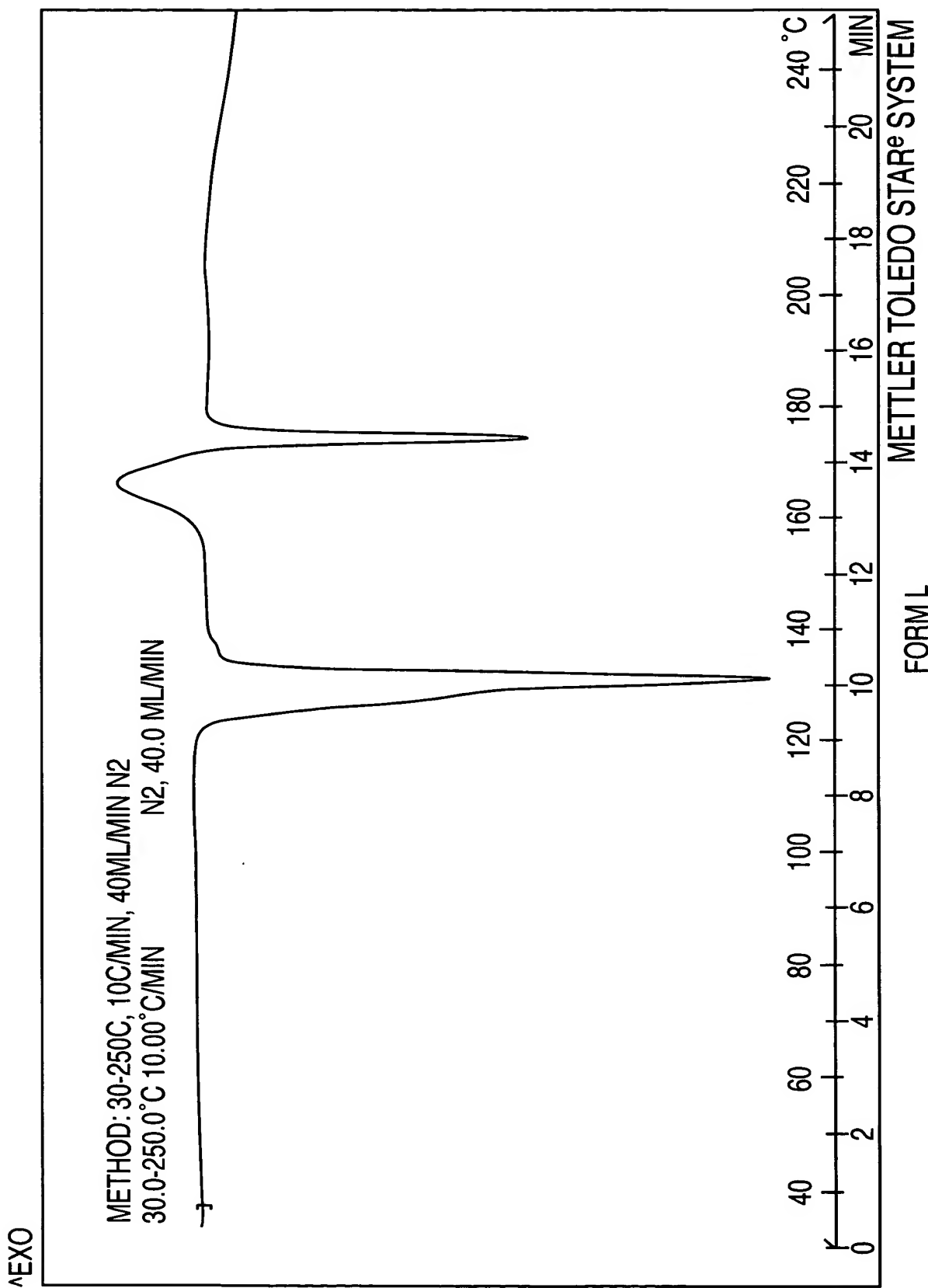


FIG. 44

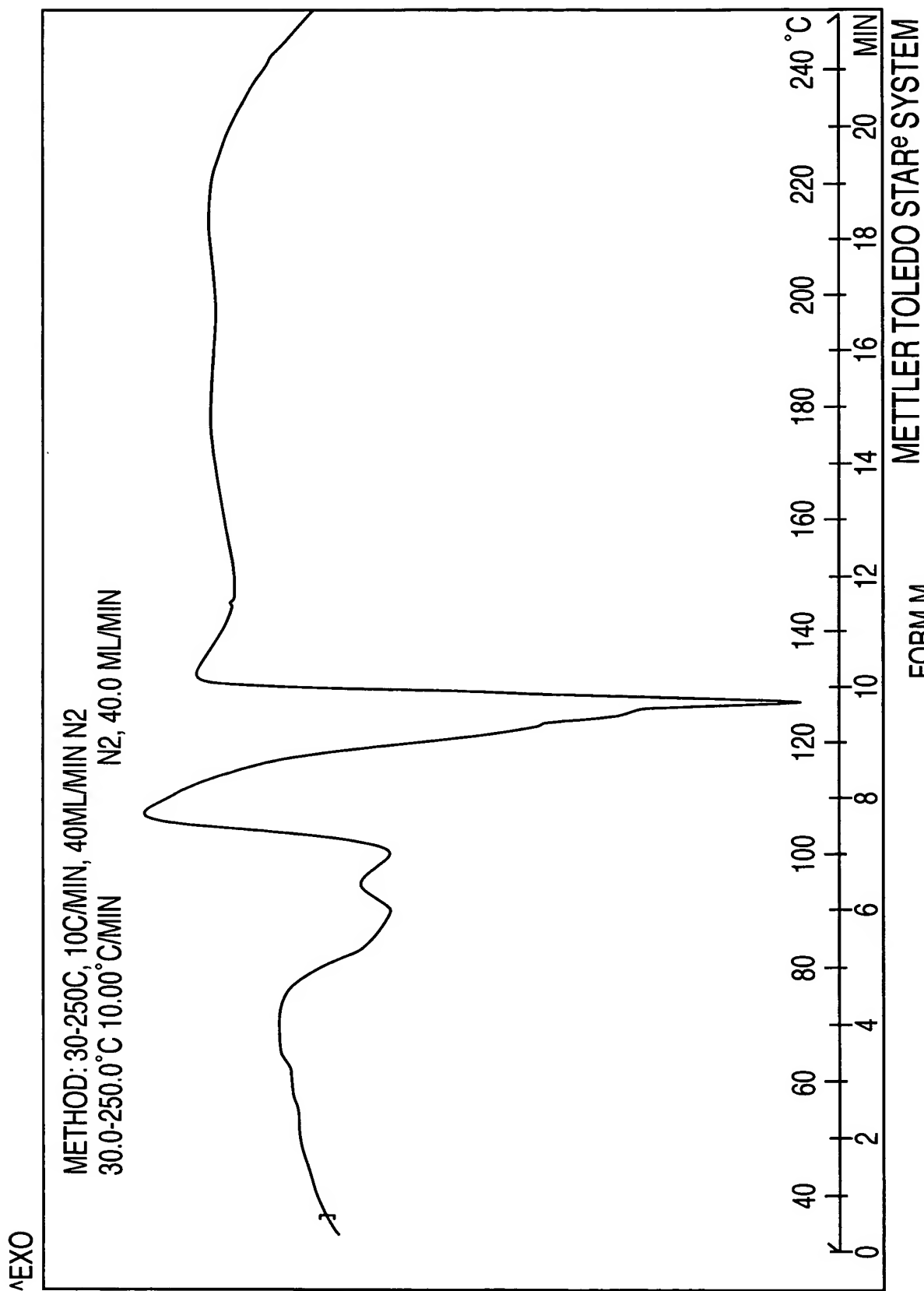
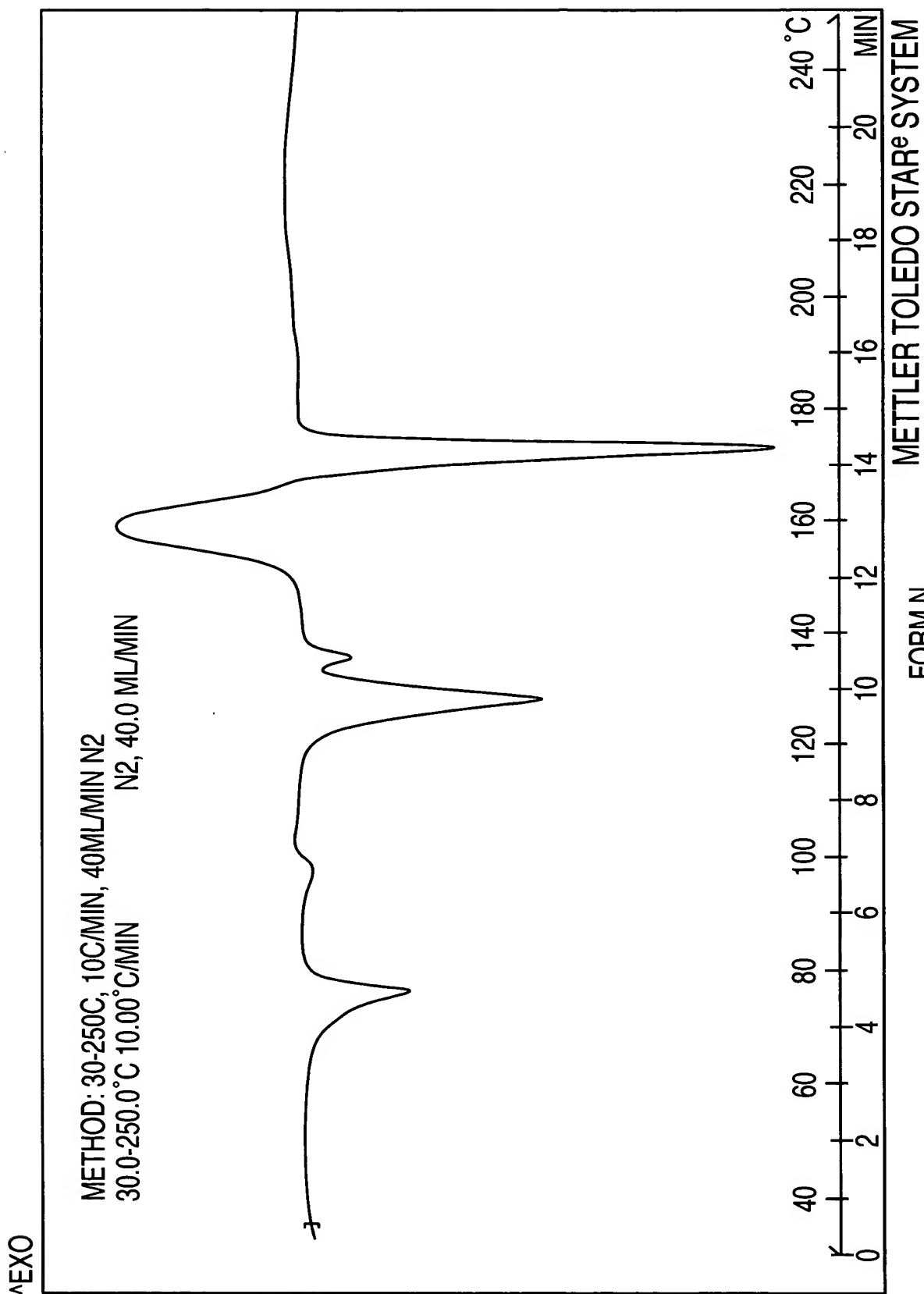
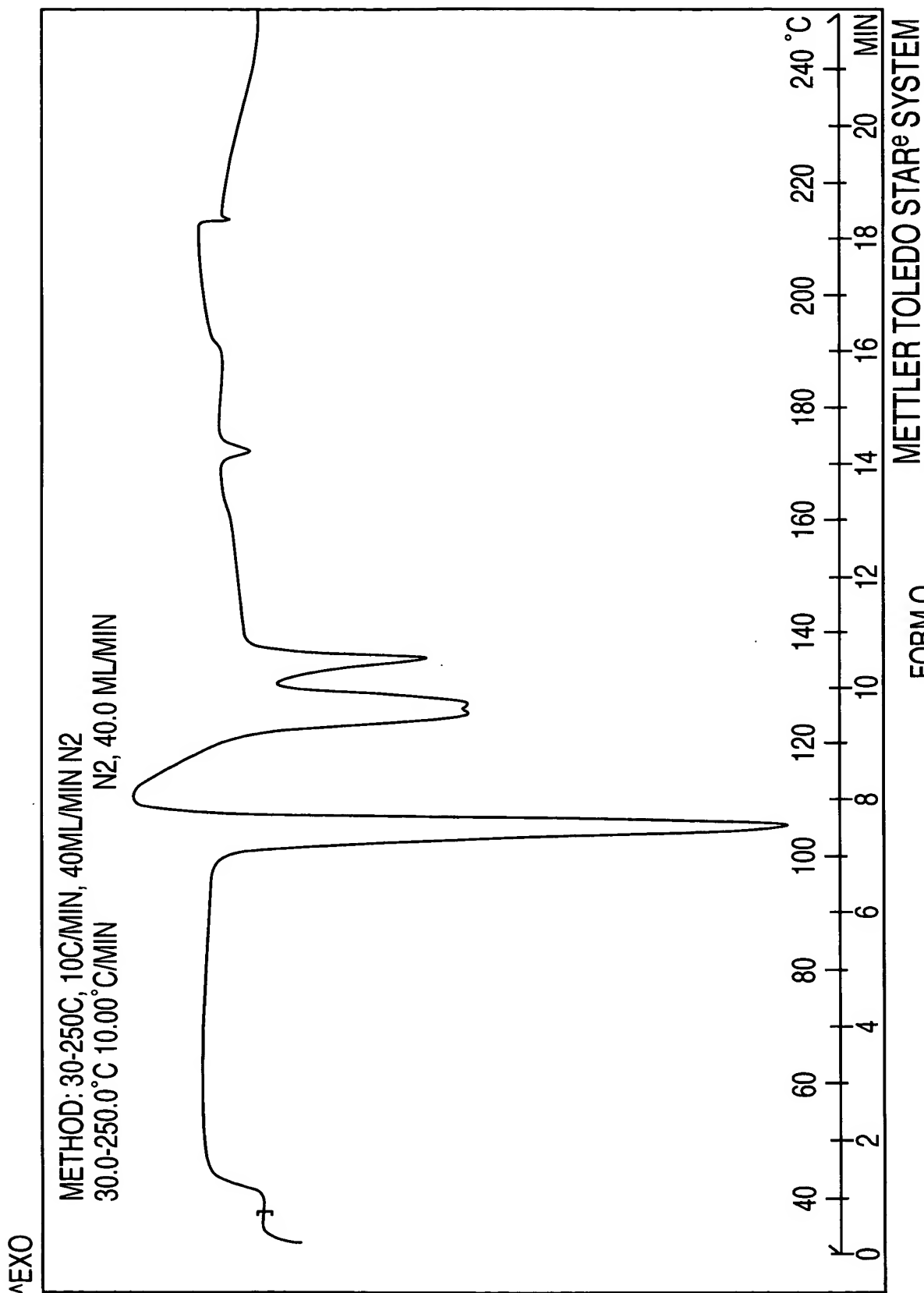


FIG. 45



FORM N

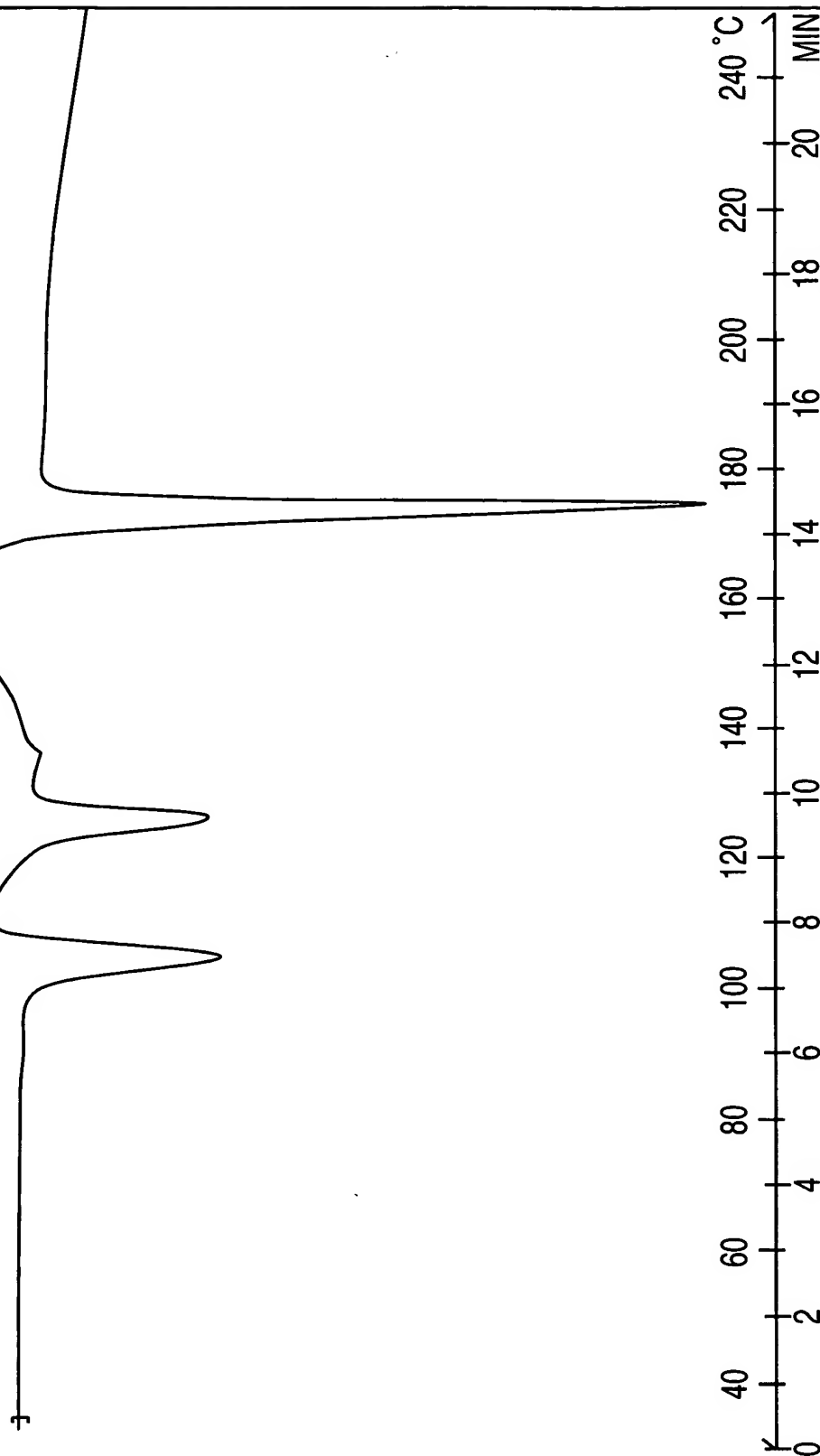
FIG. 46



FORM O
FIG. 47

^EXO

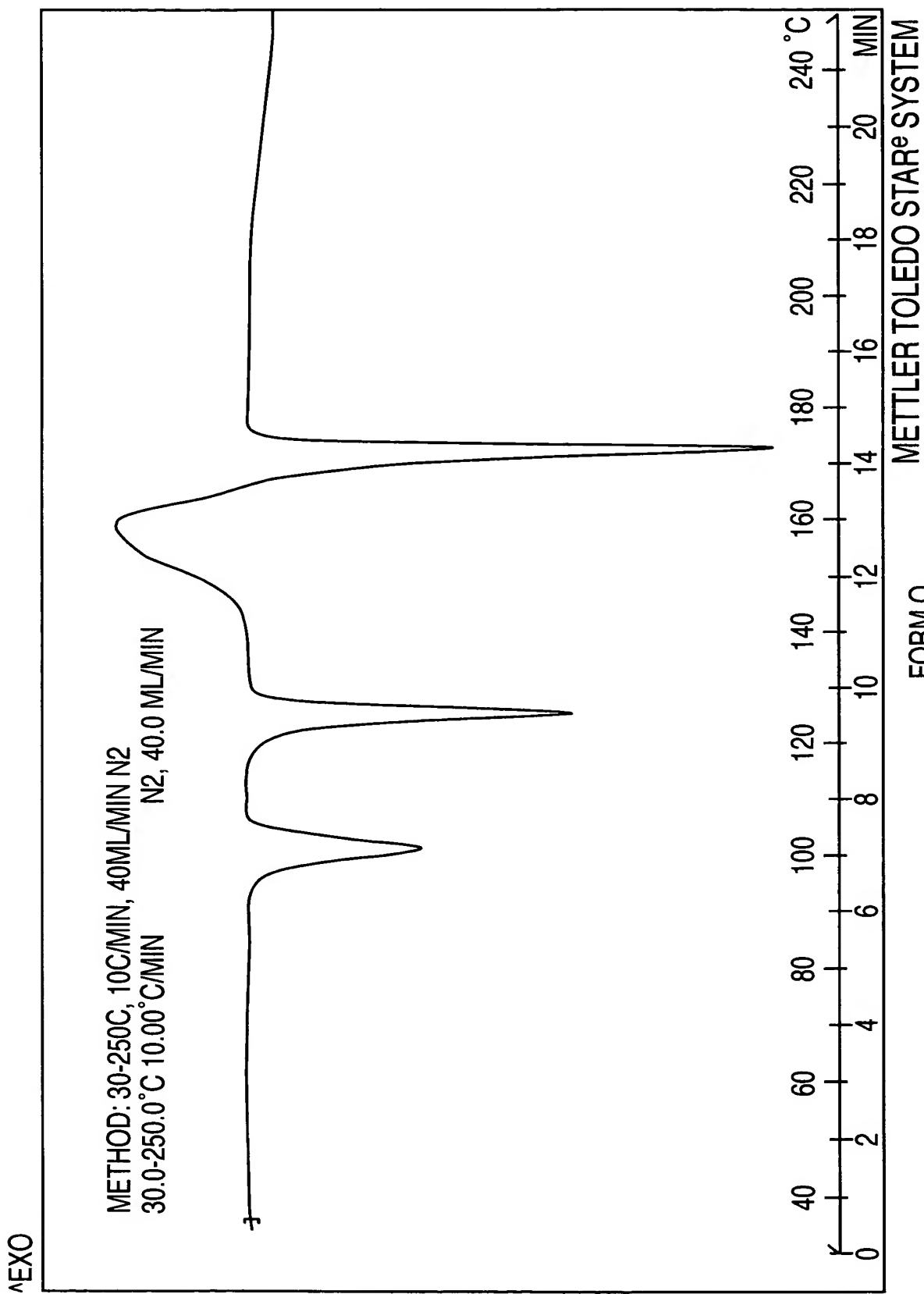
METHOD: 30-250C, 10C/MIN, 40ML/MIN N2
30.0-250.0°C 10.00°C/MIN N2, 40.0 ML/MIN



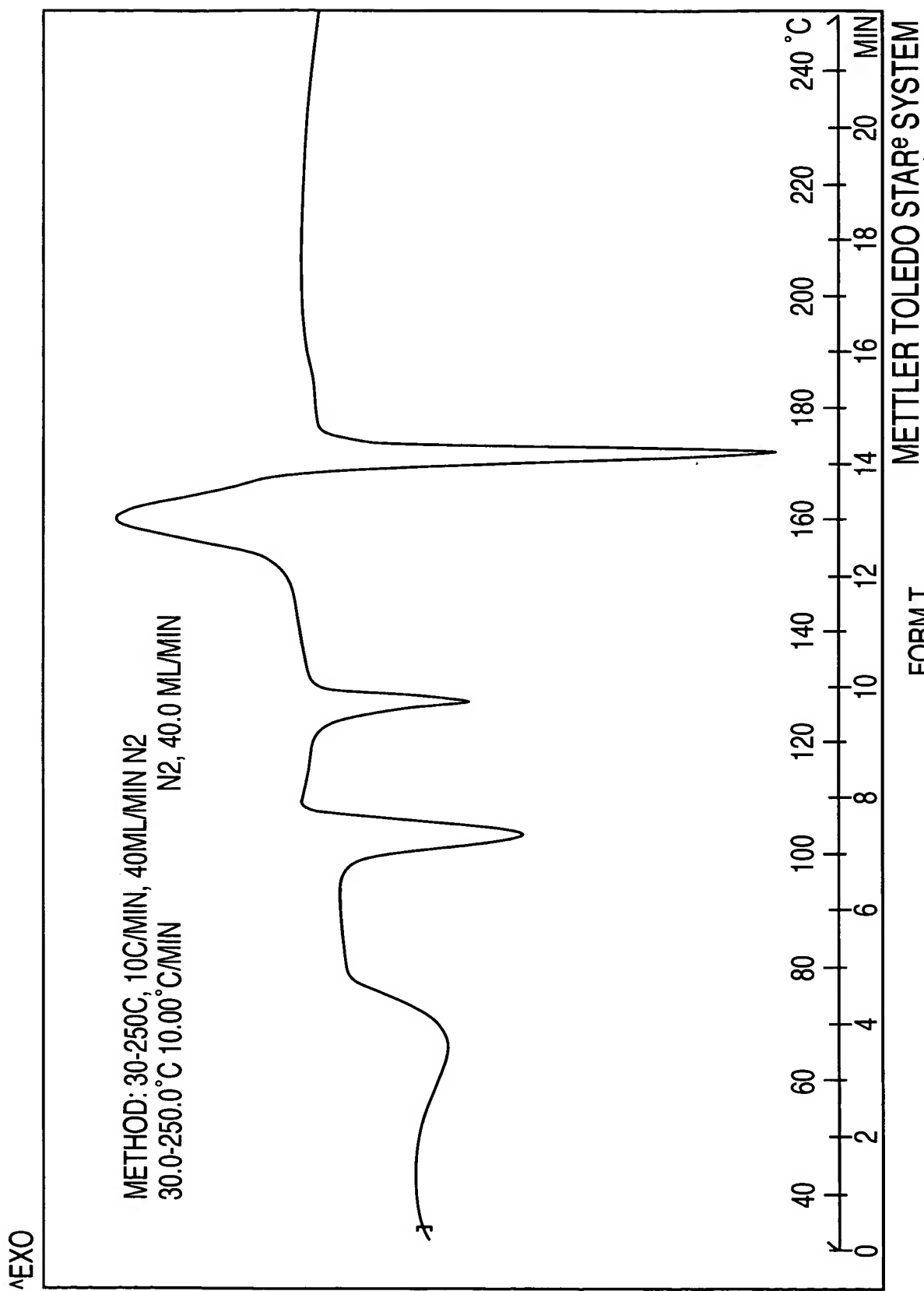
METTLER TOLEDO STAR^e SYSTEM

FORM P

FIG. 48

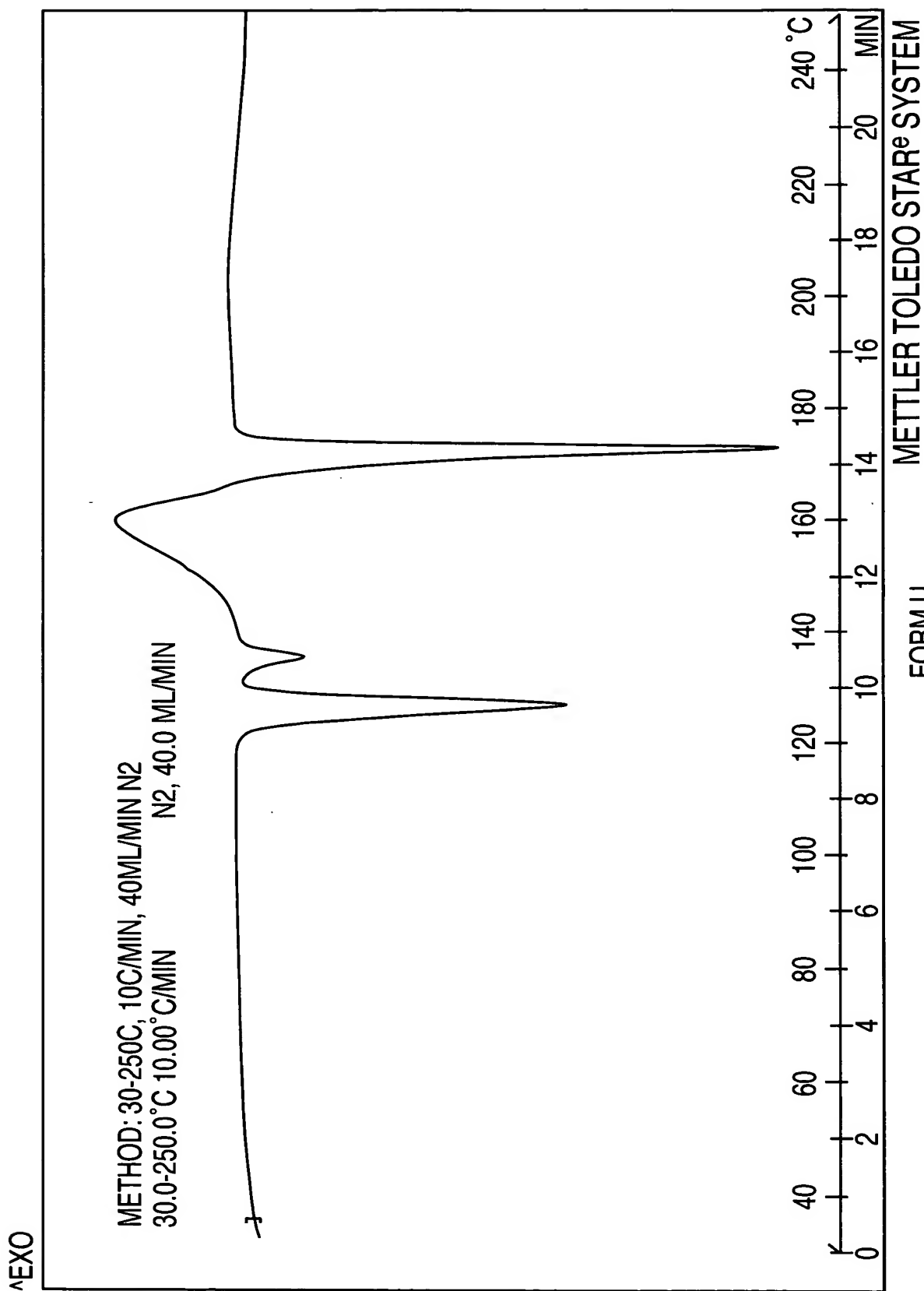


FORM Q
FIG. 49



FORM T

FIG. 50

FORM U
FIG. 51

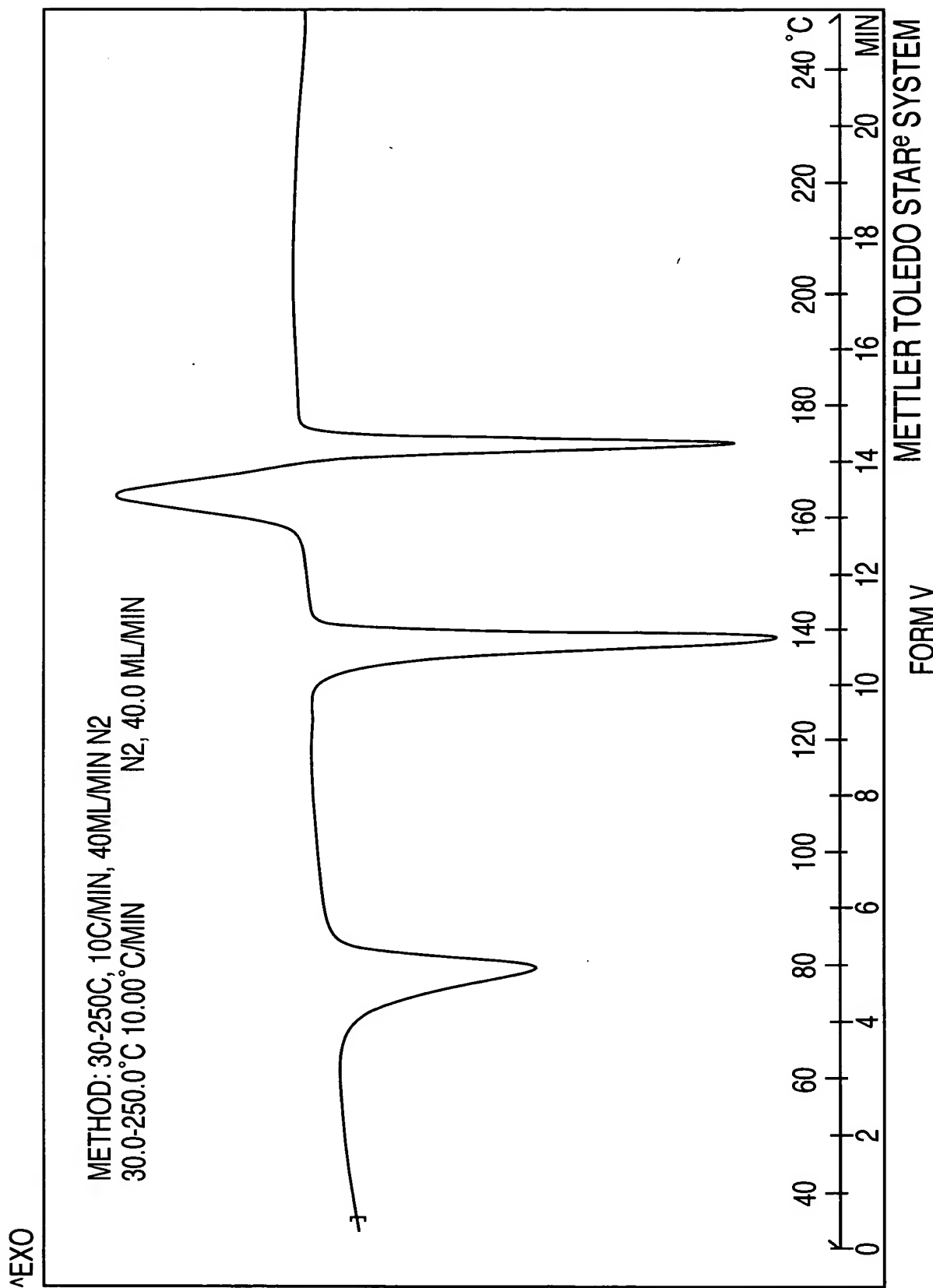
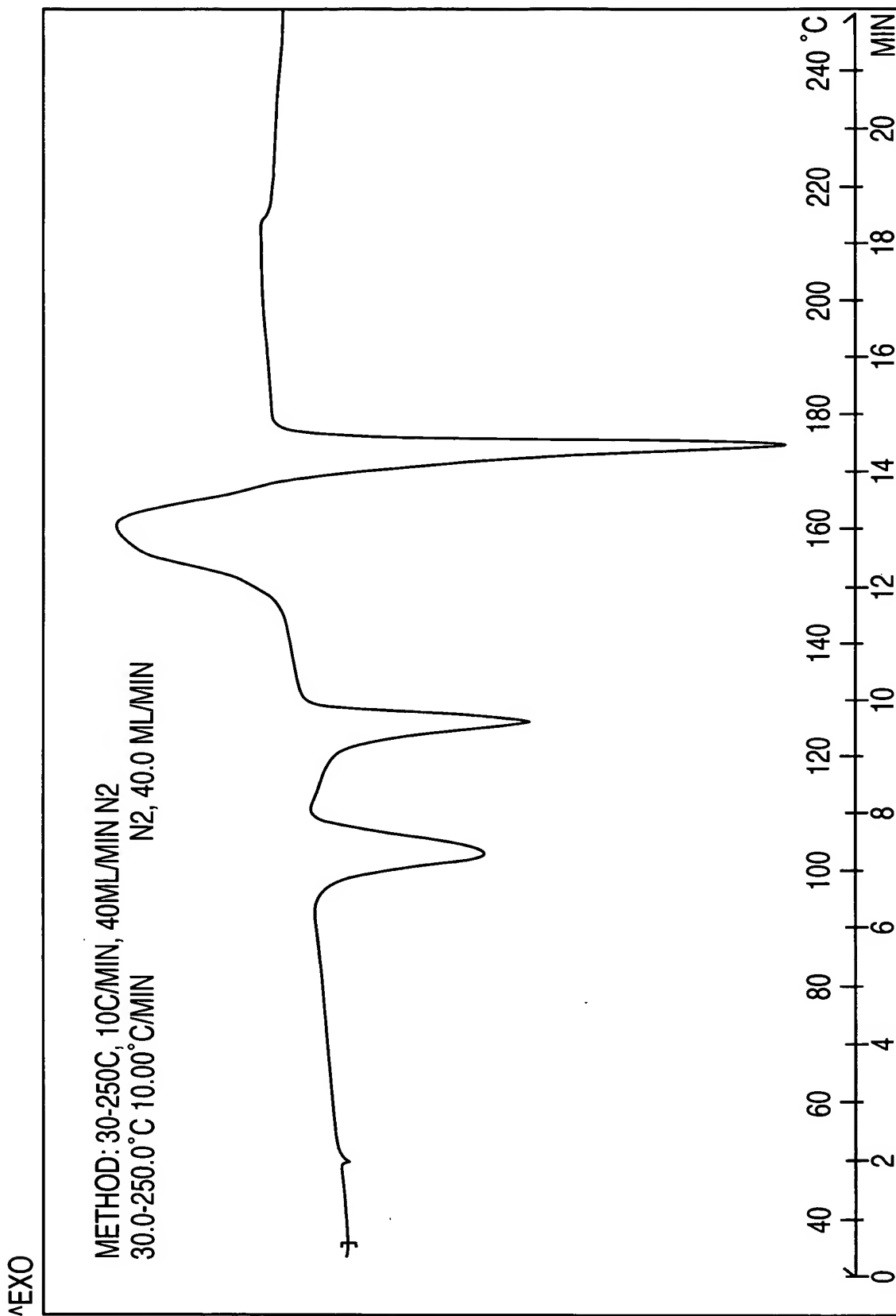
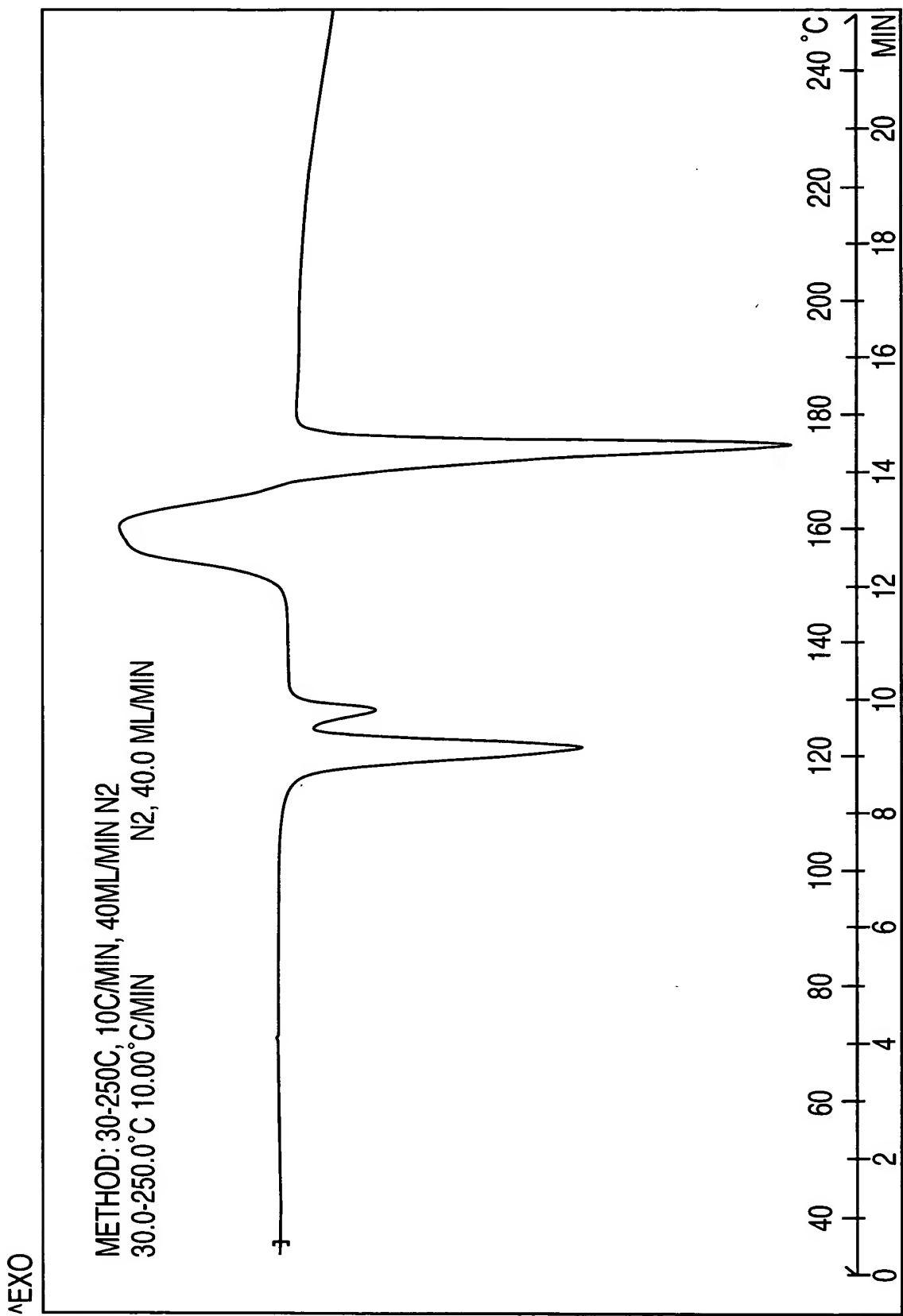


FIG. 52

METTLER TOLEDO STAR^e SYSTEM

FORM Y (CHLOROFORM SOLVATE)

FIG. 53

METTLER TOLEDO STAR^e SYSTEM

FORM Y (DICHLOROMETHENE SOLVATE)

FIG. 54

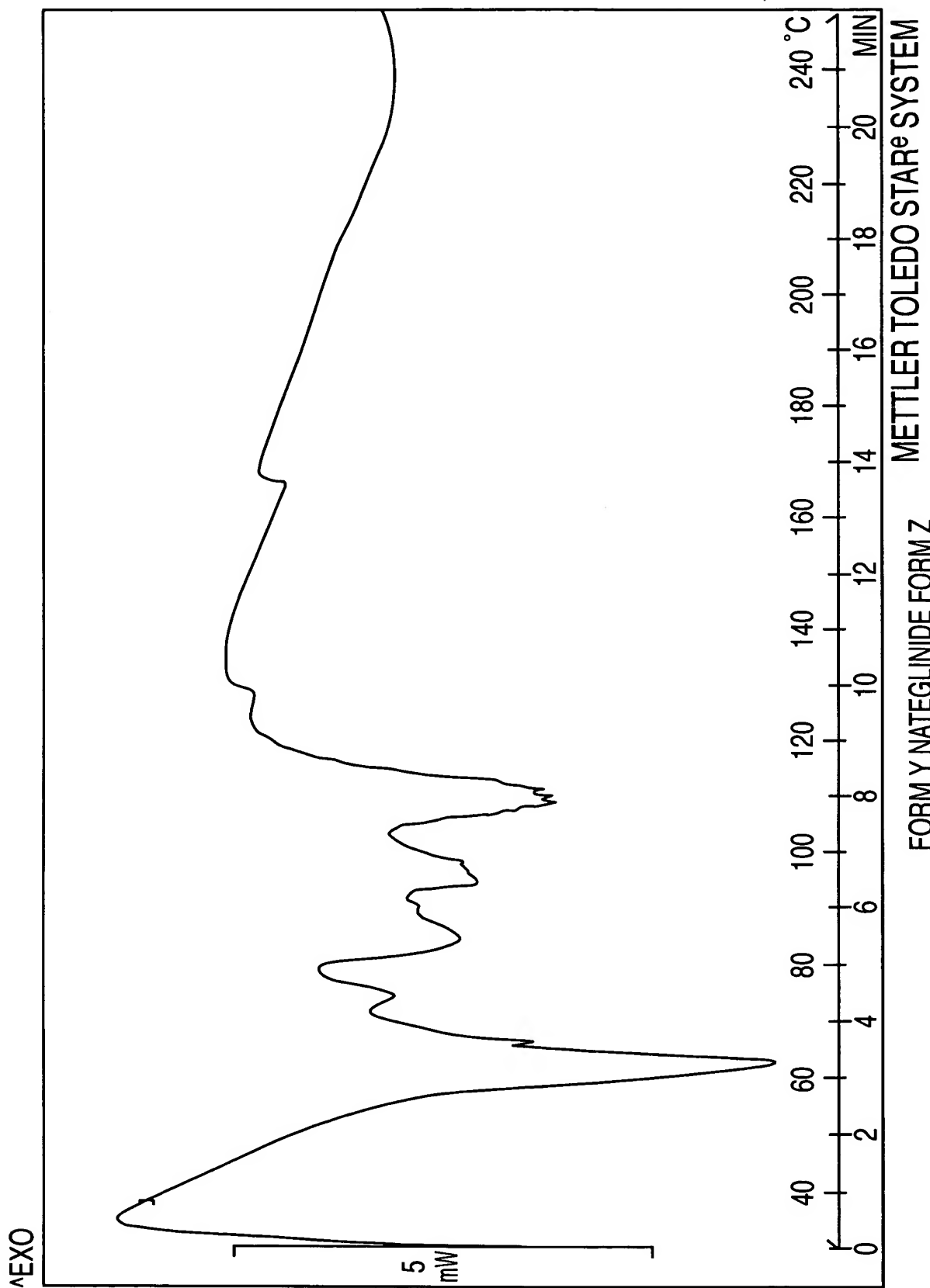
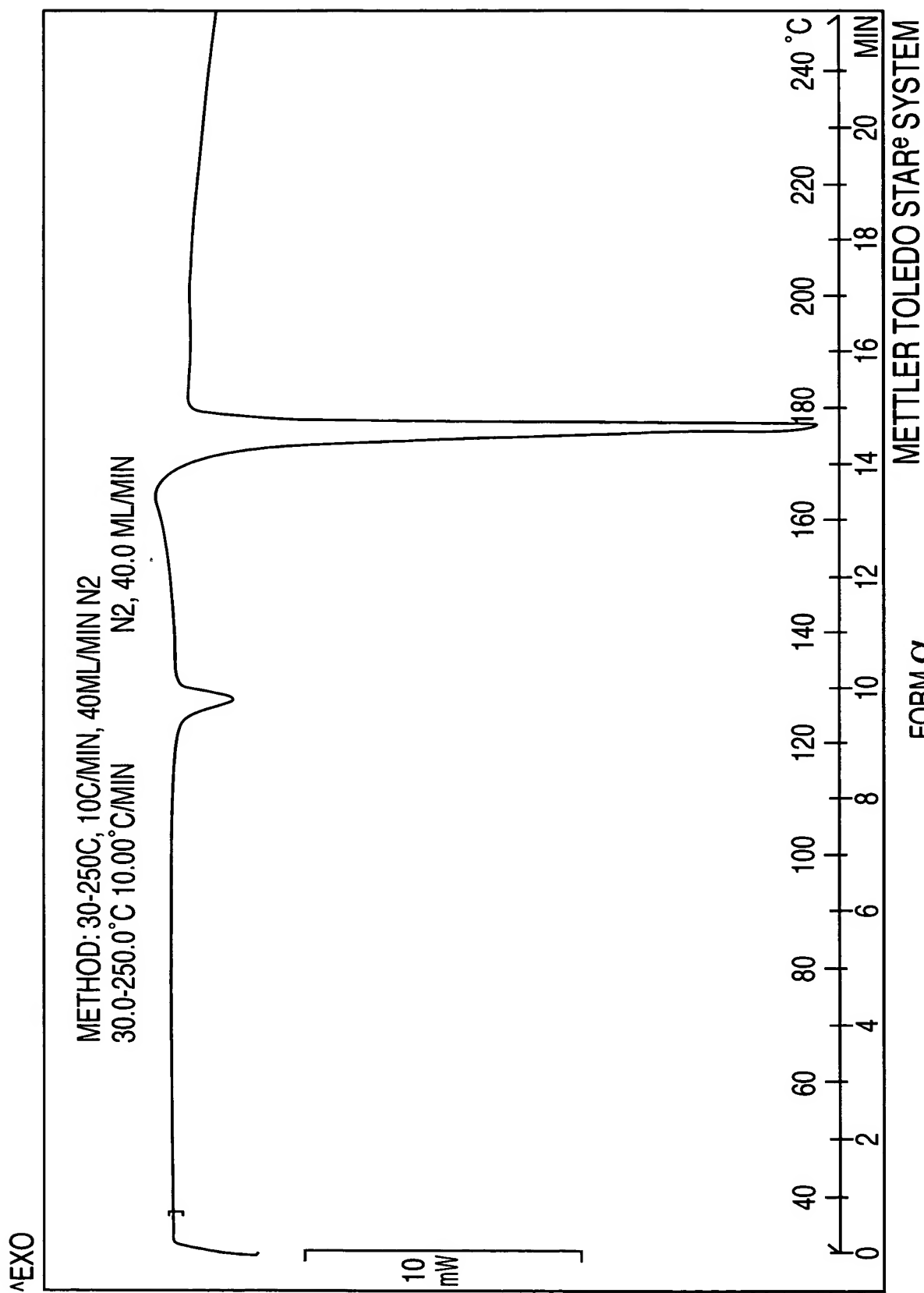
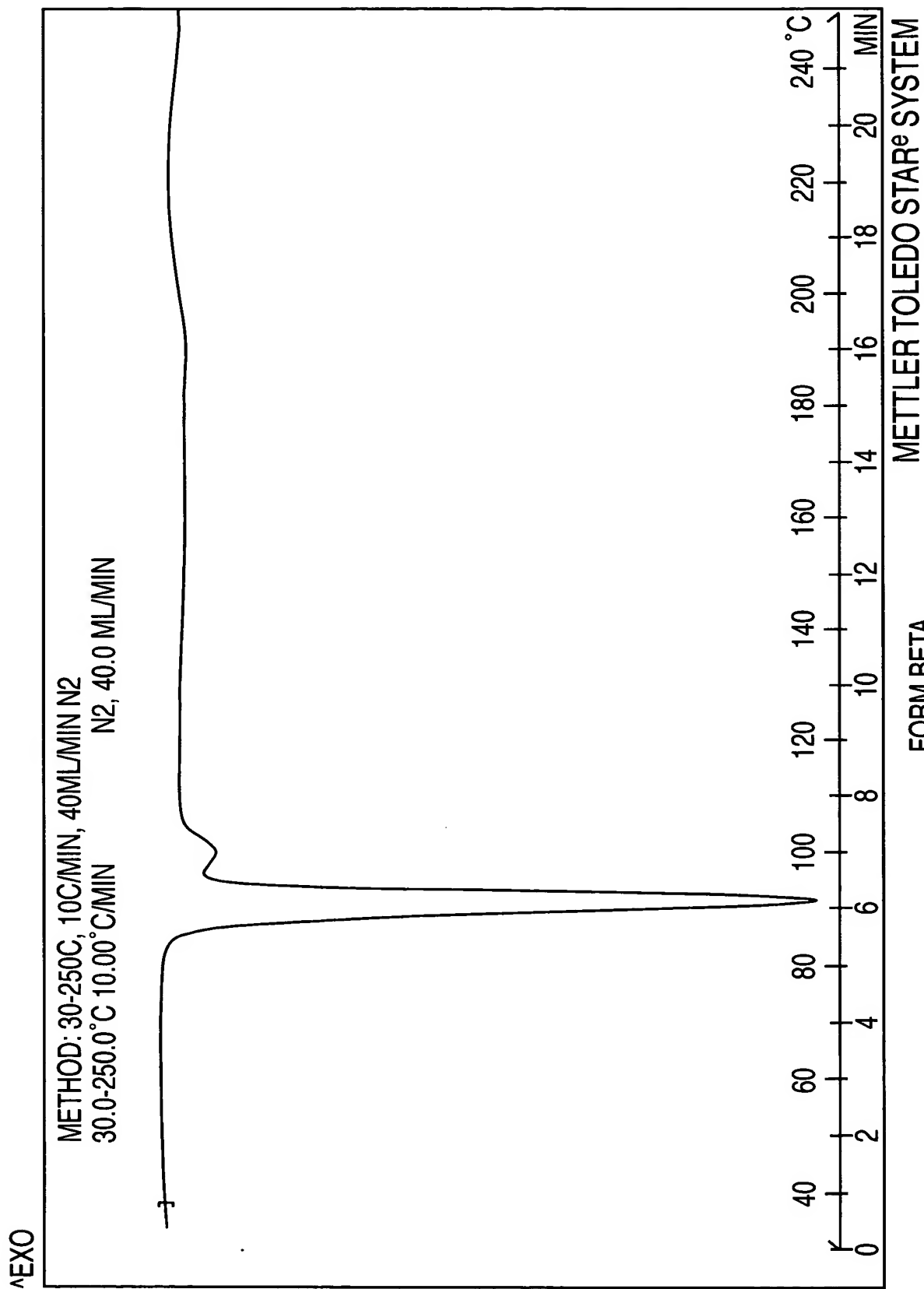


FIG. 55





FORM BETA

FIG. 57

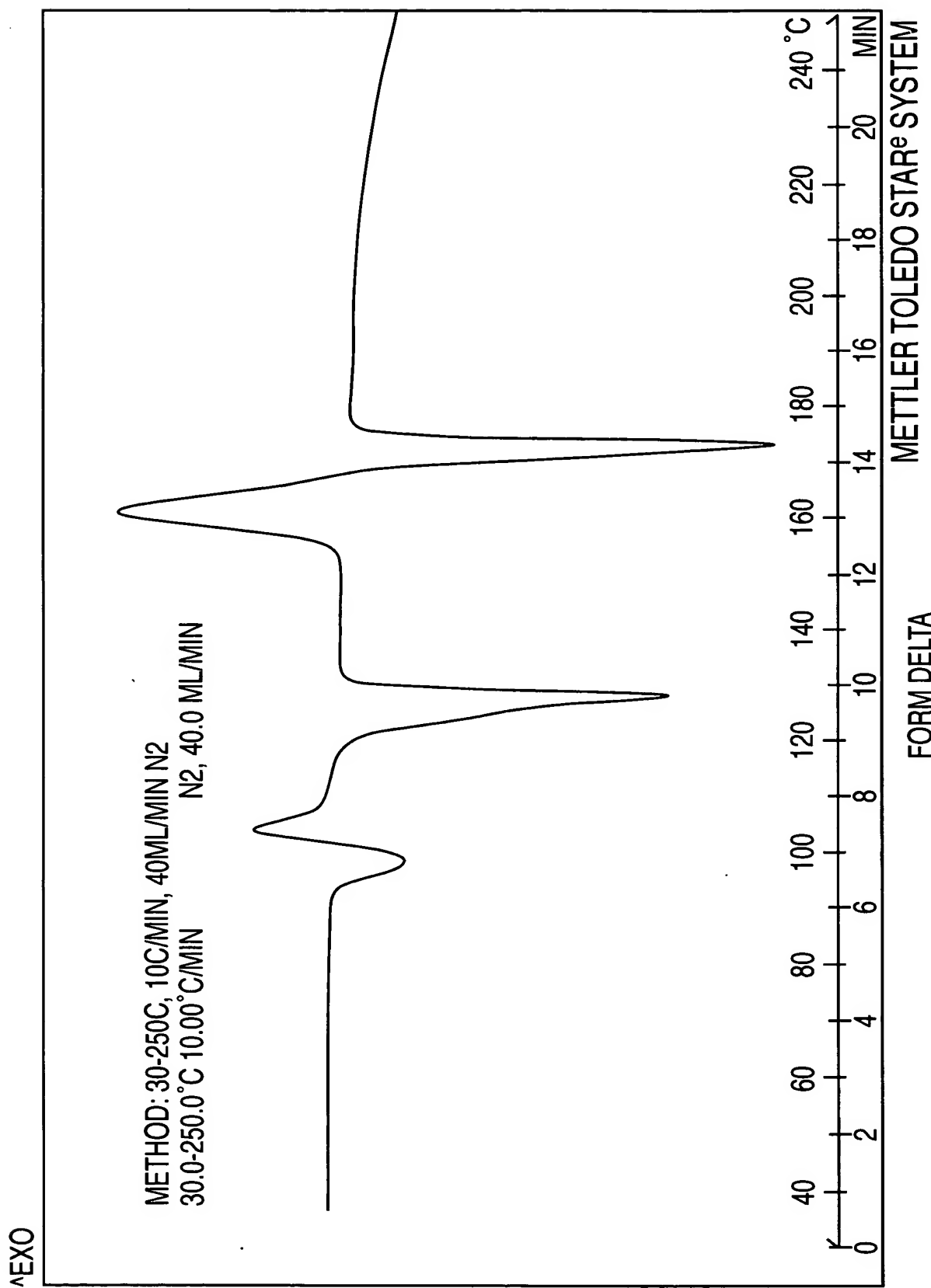


FIG. 58

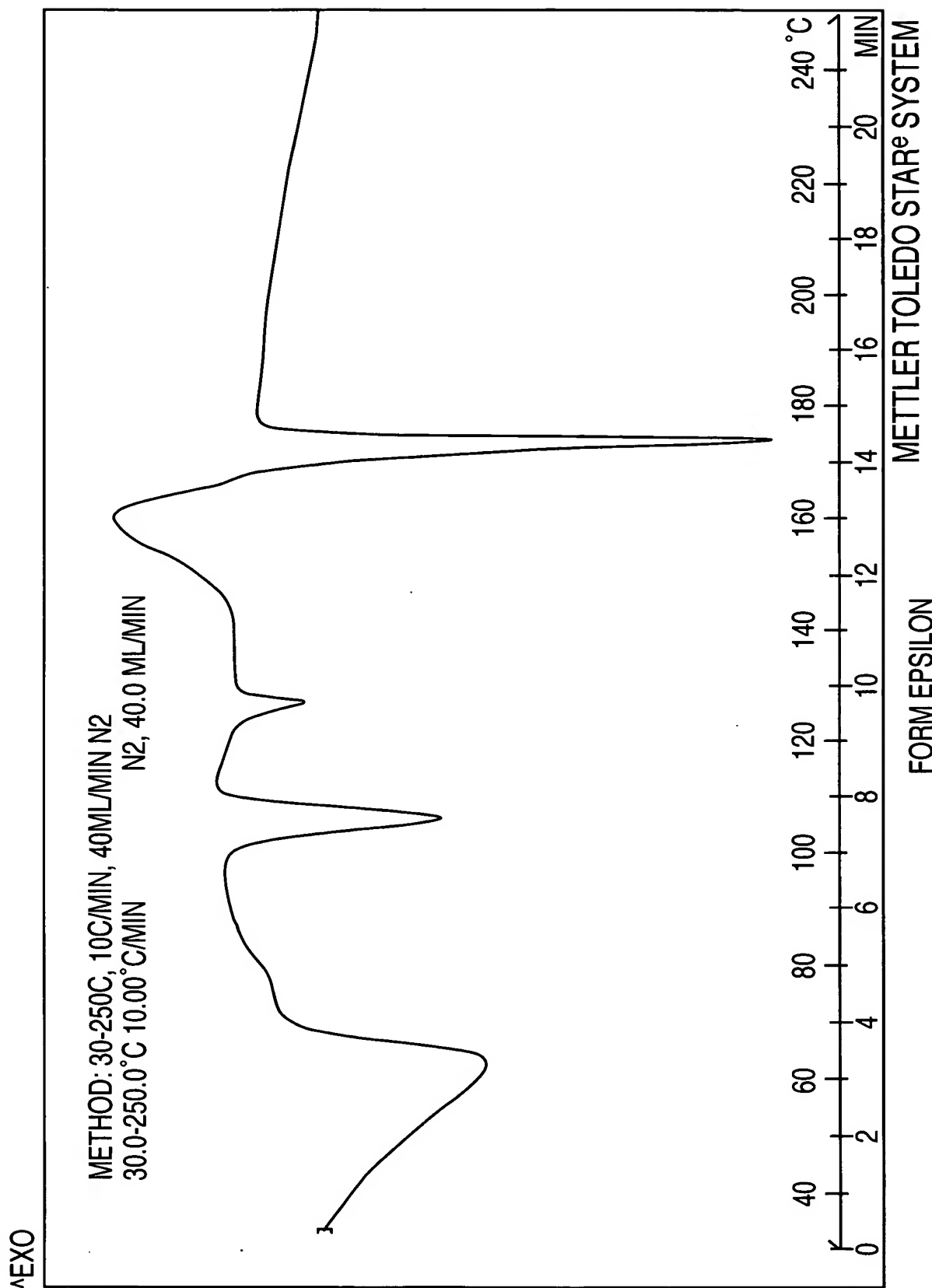
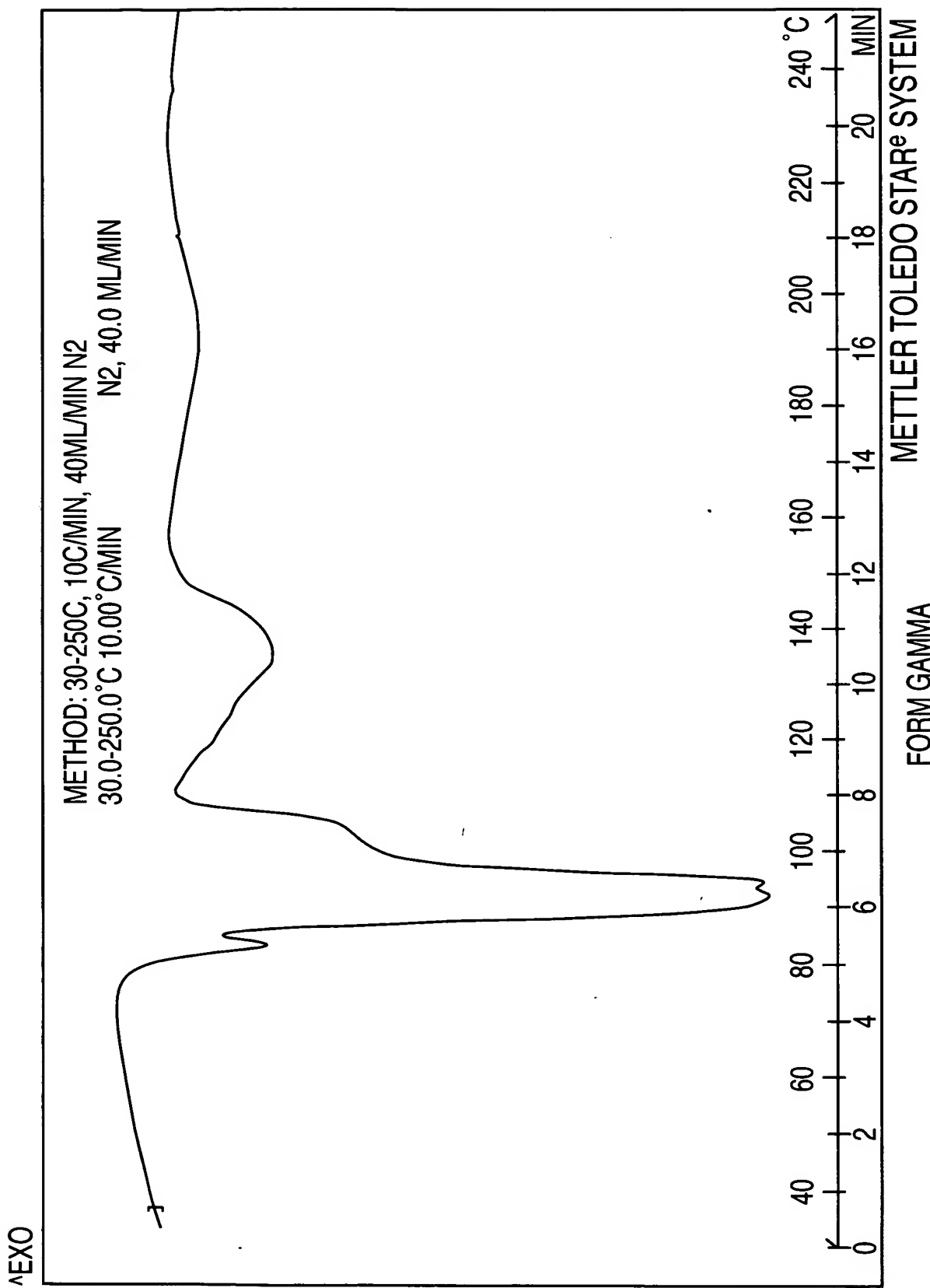


FIG. 59



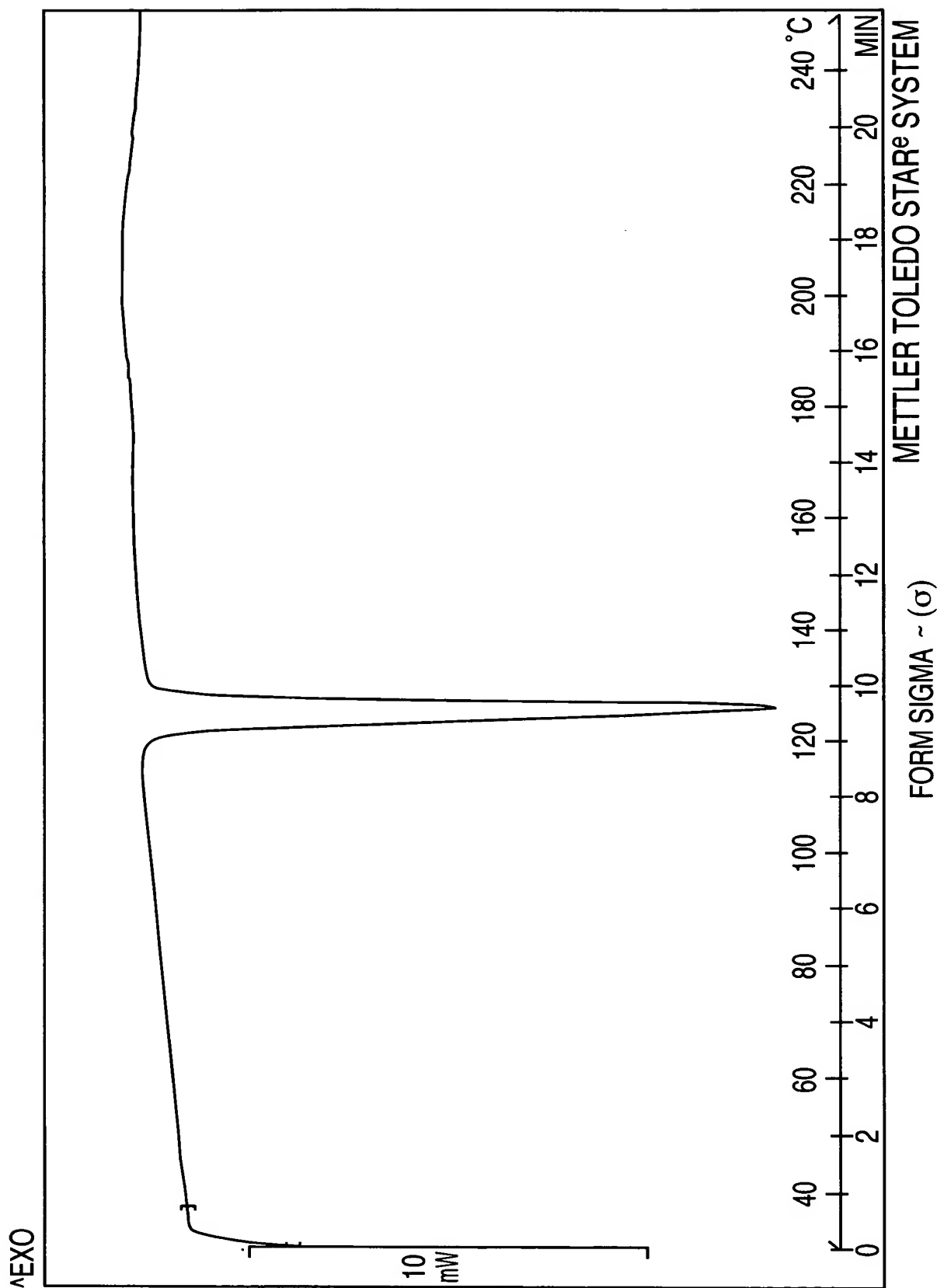
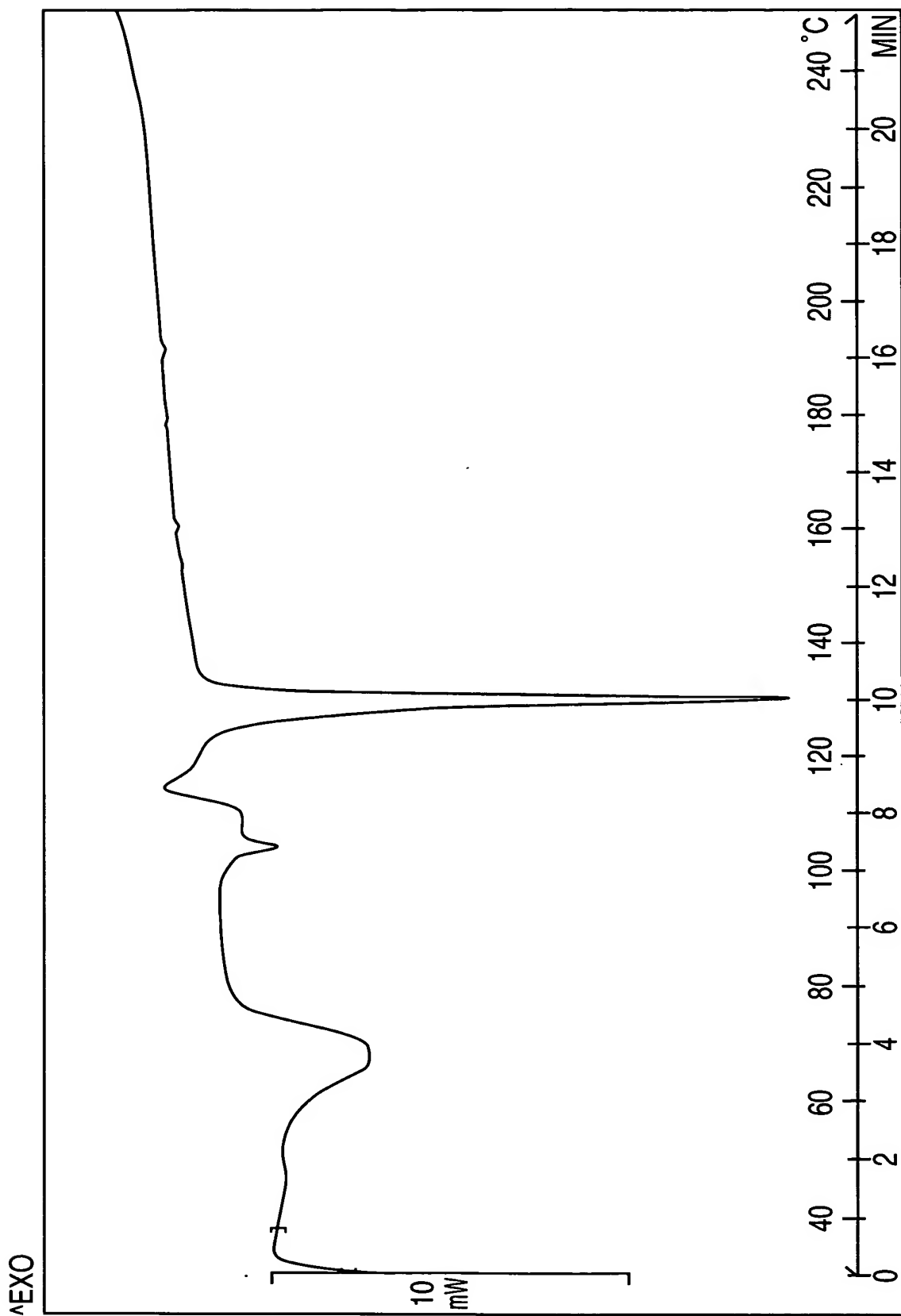


FIG. 61



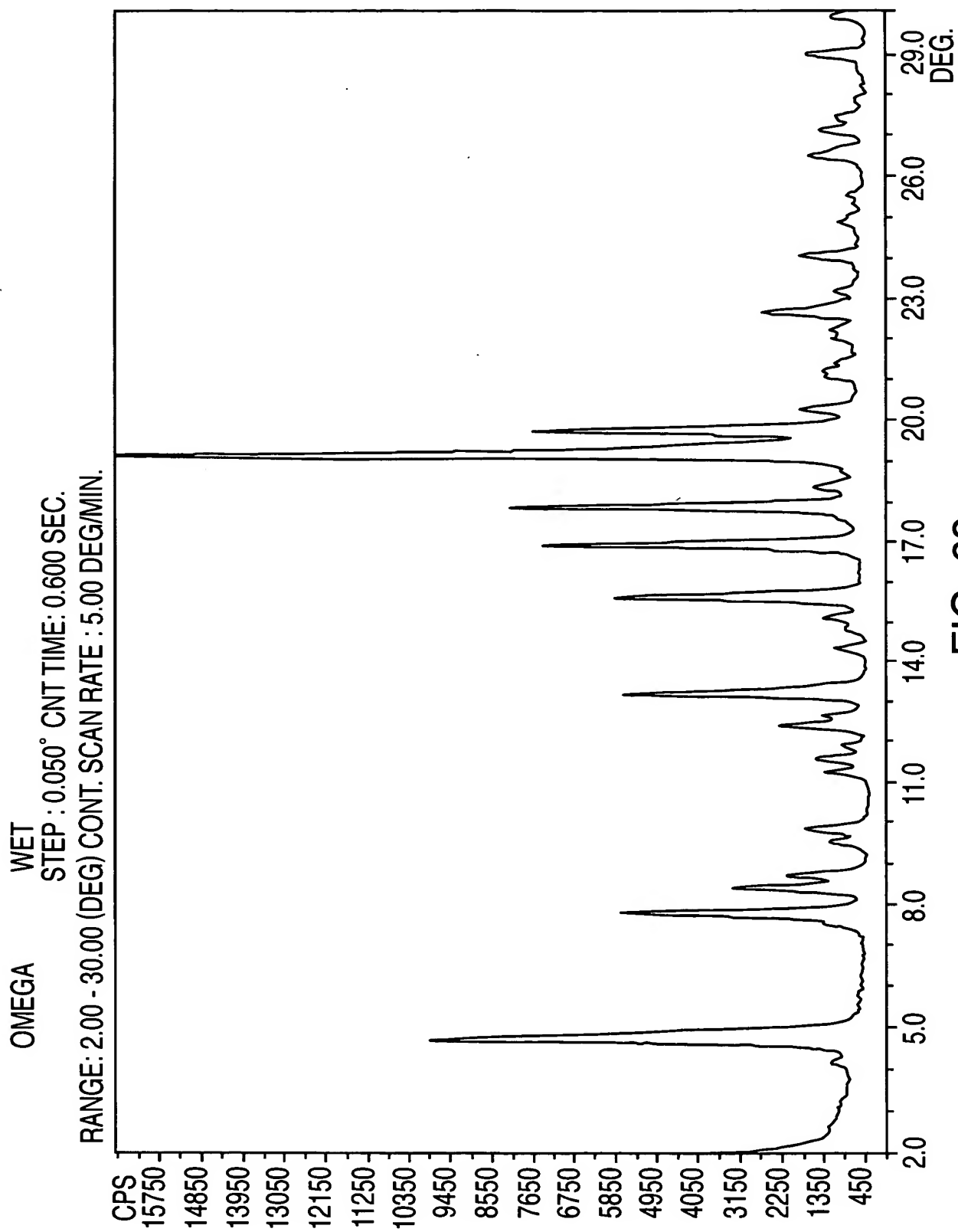


FIG. 63

Comparison between the impurity profile of Nateglinide crystallized in IPA-H₂O and Nateglinide in Methanol-H₂O

Sample No	Solvent	Impurity profile by RRT [% w/w]								
		D-PA (0.23)	(0.25)	(0.46)	(0.80)	Ipcha (0.89)	Dimer (1.38)	Methyl Ester (1.51)	(1.76)	Isopropyl Ester (2.3)
RL-2155/1	Methanol-H ₂ O	<0.01		0.02	<0.01	0.03	0.02	2.91	0.04	
RL-2163/4	IPA-H ₂ O	<0.01	0.04		0.02	0.02	0.01		0.03	0.02

Note: D-PA means D-Phenyl Alanine

Ipcha means Iso propyl cyclohexyl carboxylic acid

Both are the starting materials of the product

(-)-N-[(trans-4-isopropyl cyclohexane)carbonyl]-D-phenylalanine

FIG. 64